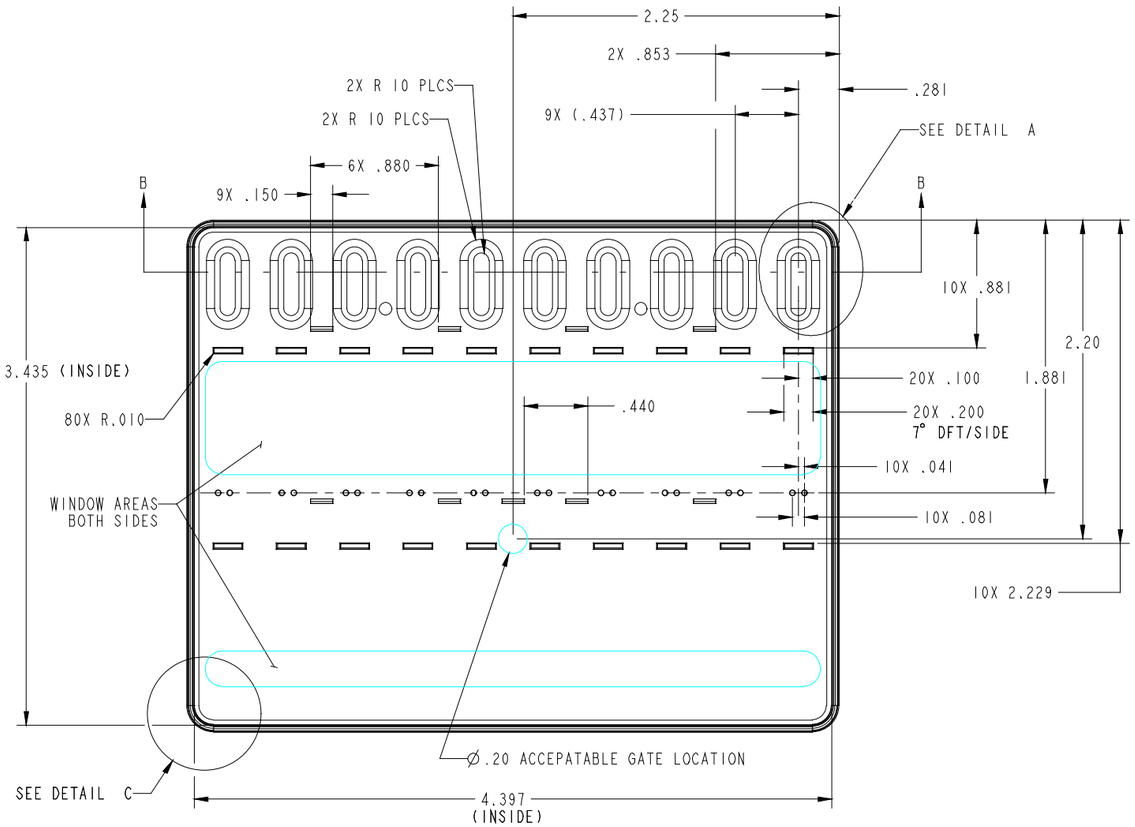
Joint Portal Shield Carrier Assembly Drawings and Specifications

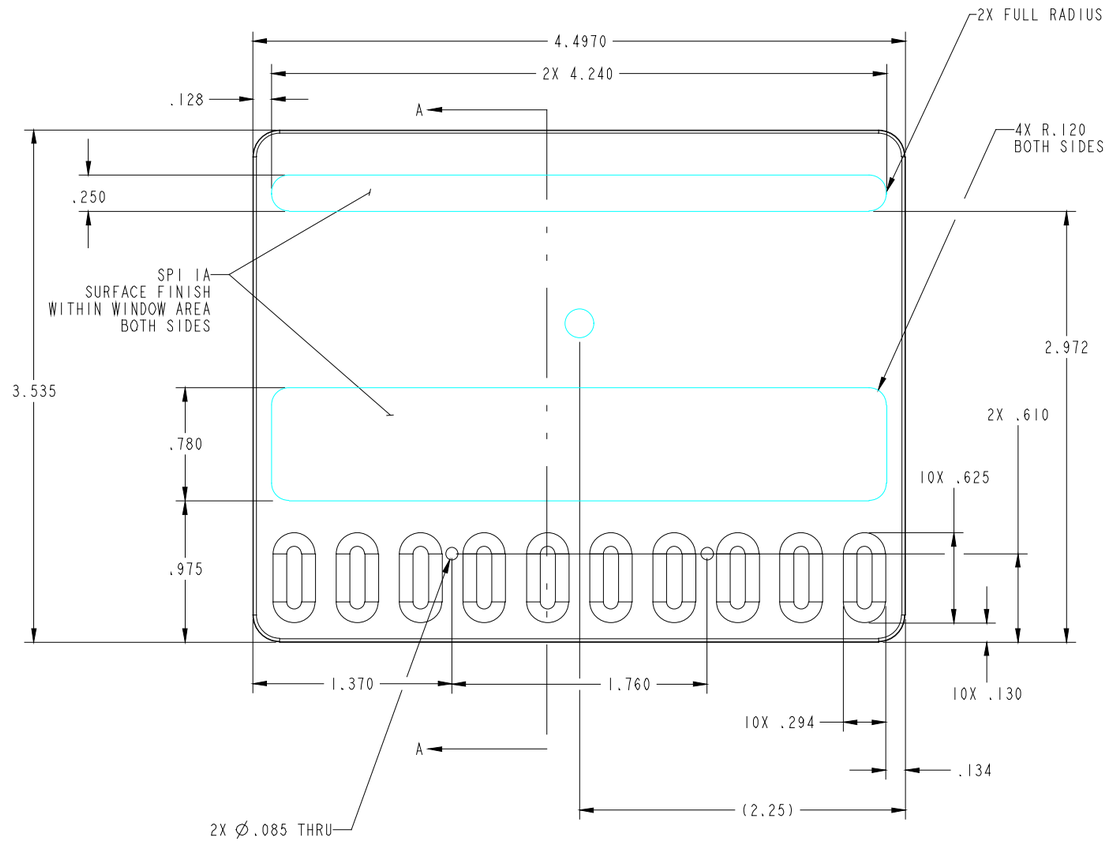
Table of Contents:

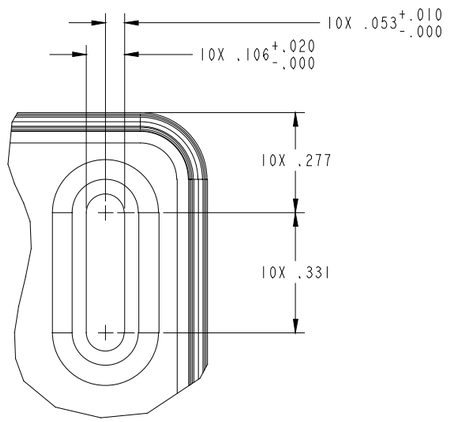
DWG NO.	PAR3-PC3	SH	1	REV	C

REVISIONS			
LTR	DESCRIPTION	DATE	APPROVAL
A	UPDATED MODEL AND DRAWING	7/15/02	KHR
B	RELEASED FOR MANUFACTURE	7/30/02	DLD
C	DIM 10X .053 WAS .046, 10X .106 WAS .091, ZONE B6 SHT 1, (.436 EAS (.422), 10X .079 WAS .085 ZONE B4 SHT 2	6/16/03	KHR

CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY







DETAIL A
SCALE 5/1

NOTES:
1. REMOVE ALL FLASH
2. FLAT SURFACES TO HAVE FLATNESS TOLERANCE OF .005/IN AND NOT TO EXCEED .020 OVER ENTIRE LENGTH OF PART

NEXT ASSY	USED ON
APPLICATION	

GENERAL TOLERANCES		
XX DECIMALS	XXX DECIMALS	ANGLES
±0.04	±0.010	±2.0

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
REMOVE BURRS AND BREAK SHARP EDGES .015 MAX
INSIDE CORNERS R .015 MAX
SURFACE FINISH 125

MATERIAL: LEXAN, HF 1140-112, CLEAR

DO NOT SCALE THIS DRAWING

SENTEL		
BETAC		
B52		
CHECKED		
DRAWN	MJS	26-Nov-01
APPROVED FOR NAVSEA		DATE

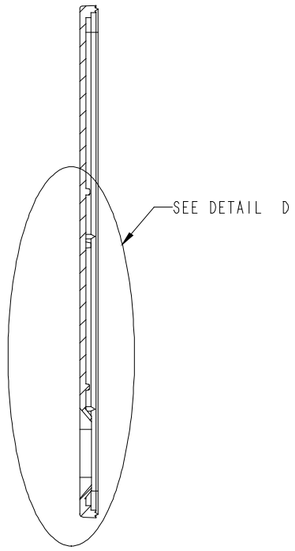
ACS DEFENSE INC.
5290 SHAWNEE RD
ALEXANDRIA VA 22312

TOP, ASSAY

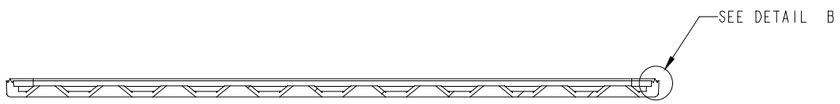
SIZE	CAGE CODE	GIN	DWG NO.	REV
D	07609	-	PAR3-PC3	C

SCALE: 2/1 | WEIGHT: | SHEET 1 OF 2

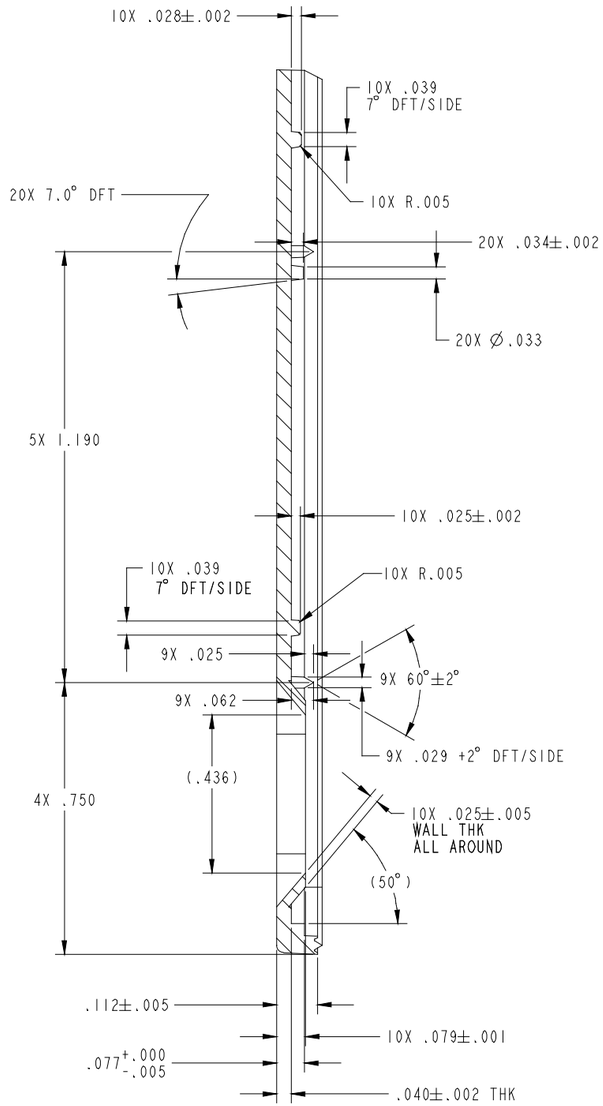
PROE DRAWING: PAR3-PC3 PROE MODEL: SK526-9570 26-Nov-01 MJS



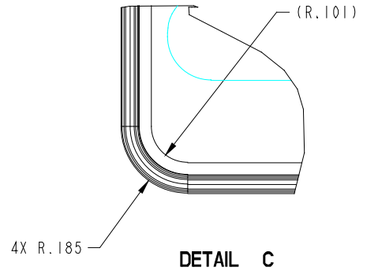
SECTION A-A



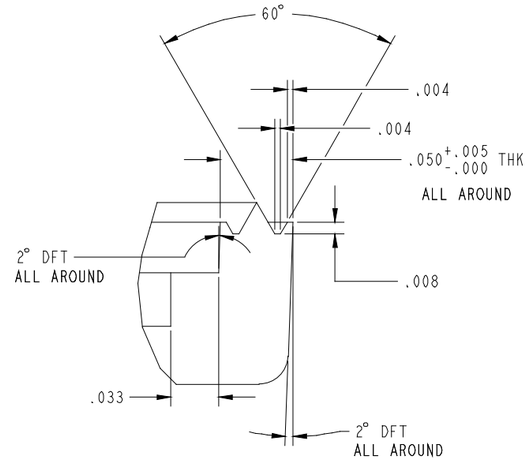
SECTION B-B



DETAIL D
SCALE 5/1



DETAIL C
SCALE 5/1



DETAIL B
SCALE 20/1

SIZE	CAGE CODE	GIN	DWG NO.	REV
D	07609	-	PAR3-PC3	C
SCALE: 2/1			SHEET 2 OF 2	

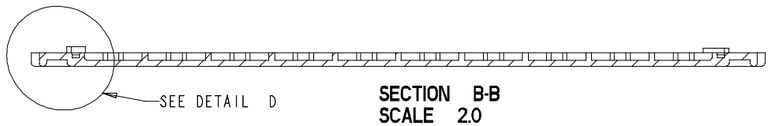
PROE DRAWING: PAR3-PC3 PROE MODEL: SK526-9570 31-Jul-02 MJS

DWG NO. PAR3-PC1 SH 1 REV D

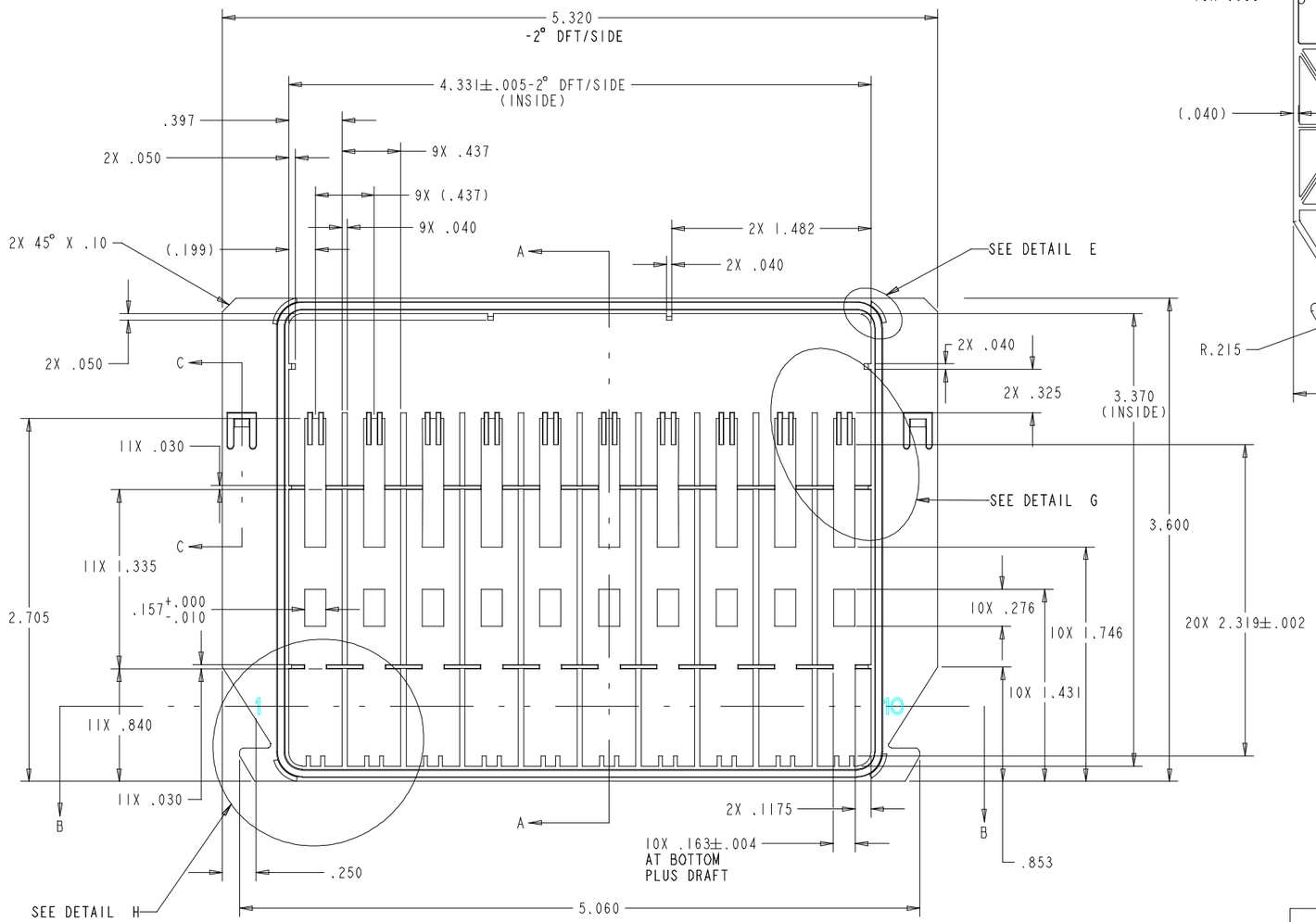
CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY

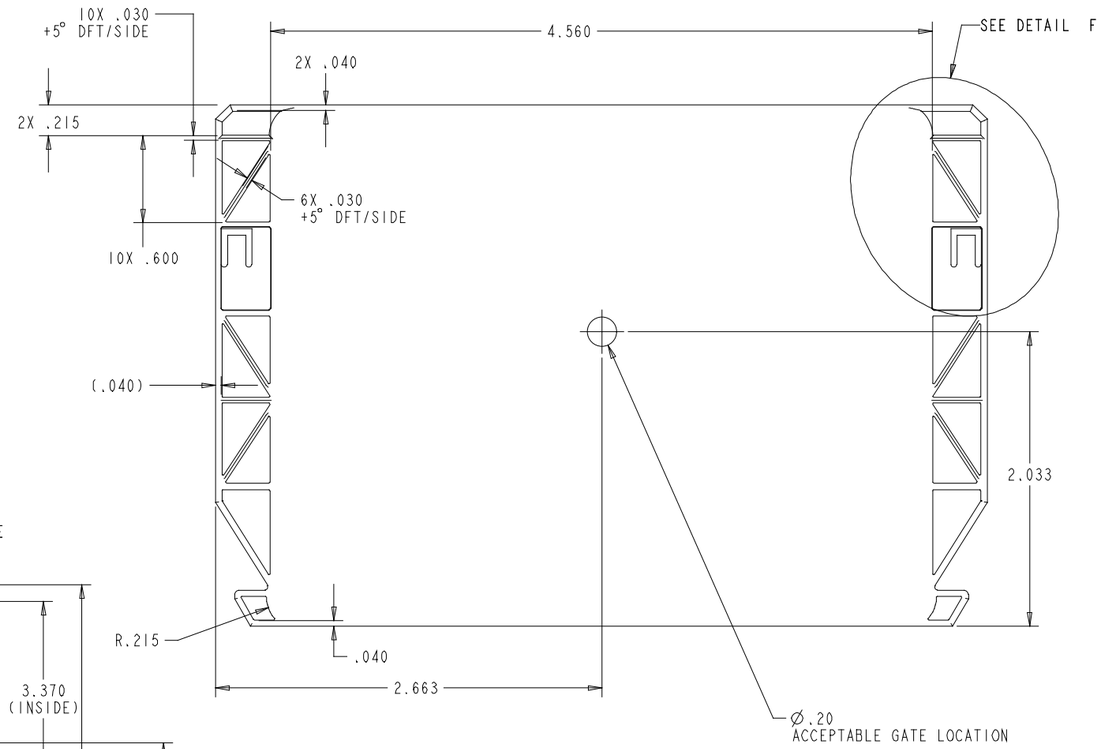
REVISIONS

LTR	DESCRIPTION	DATE	APPROVAL
A	UPDATED MODEL AND DRAWING	7/15/02	KHR
B	RELEASED FOR MANUFACTURE	7/30/02	DLD
C	DIM 11X .840 WAS 11X .690 IN ZONE A8 DIM 11X 1.335 WAS 11X 1.485 IN ZONE B8	9/13/02	KHR
D	DIM 10X .163 WAS .157, 2X .118 WAS 2X .121 IN ZONE A-6, PG 1, DIM 2.319 WAS 2.316 IN ZONE B4, PG 1, DIM .156 WAS .153 IN ZONE A1, PG 2)	10/16/02	DLD



SECTION B-B
SCALE 2.0





NOTE:
1. REMOVE ALL FLASH.
2. FLAT SURFACES TO HAVE FLATNESS TOLERANCE OF .010/IN. AND NOT TO EXCEED .030/IN. OVER ENTIRE LENGTH OF PART.
3. NOMINAL WALL THICKNESS .040 IN UNLESS OTHERWISE NOTED.
4. UNSPECIFIED RADII .010 ± .010.
5. TEXT AS SHOWN RAISED .010 TO .015 IN. HIGH.

GENERAL TOLERANCES

XX DECIMALS	XXX DECIMALS	ANGLES
±0.01	±0.005	±2.0

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
REMOVE BURRS AND BREAK SHARP EDGES .015 MAX
INSIDE CORNERS R .015 MAX
SURFACE FINISH 125

MATERIAL: LEXAN, HF1140-112

DO NOT SCALE THIS DRAWING

CHECKED		
DRAWN		10-Jul-02
APPROVED FOR NAVSEA		DATE

NEXT ASSY | USED ON
APPLICATION

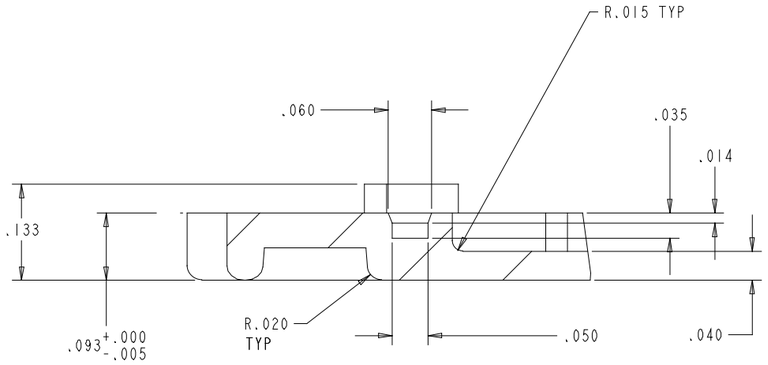
ACS DEFENSE INC.
5290 SHAWNEE RD
ALEXANDRIA VA 22312

BOTTOM, ASSAY STRIP CARRIER

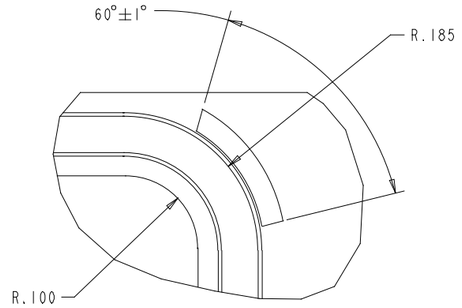
SIZE	CAGE CODE	GIN	DWG NO.	REV
D	07609	-	PAR3-PC1	D

SCALE: 2.000 WEIGHT: SHEET 1 OF 2

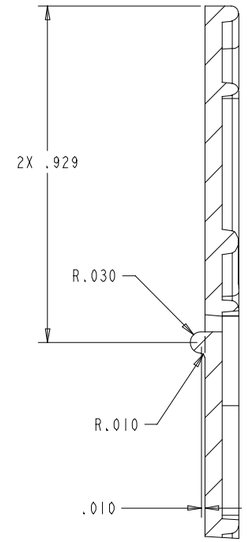
PROE DRAWING: PAR3-PC1 PROE MODEL: SK526-9571 PDMREV



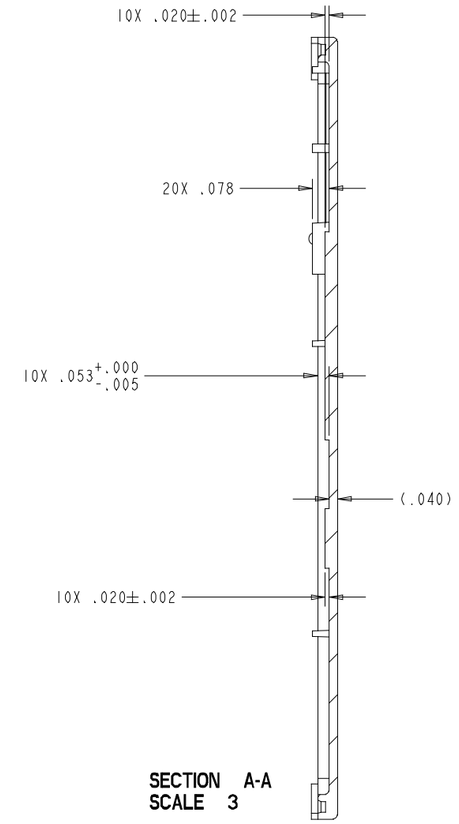
DETAIL D
SCALE 10



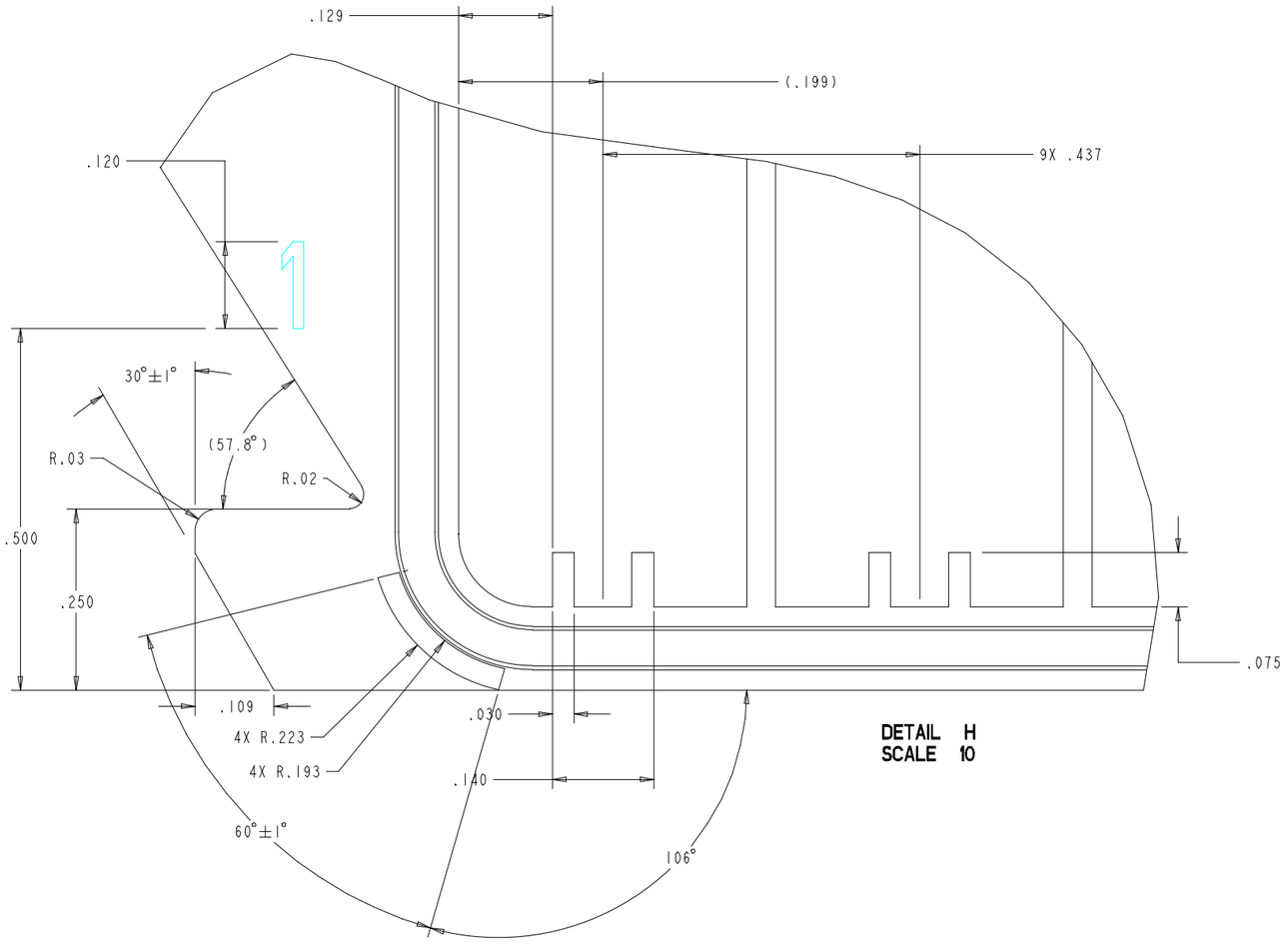
DETAIL E
SCALE 10



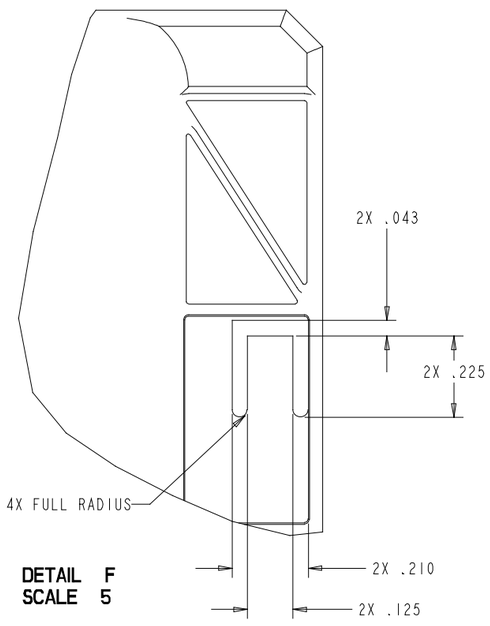
SECTION C-C
SCALE 5



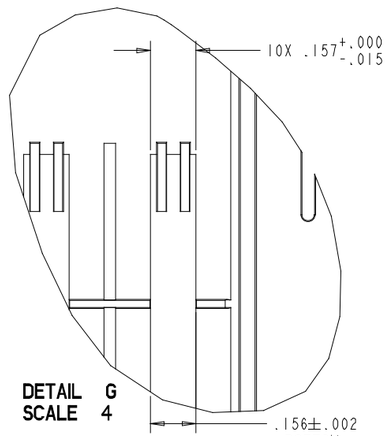
SECTION A-A
SCALE 3



DETAIL H
SCALE 10



DETAIL F
SCALE 5



DETAIL G
SCALE 4

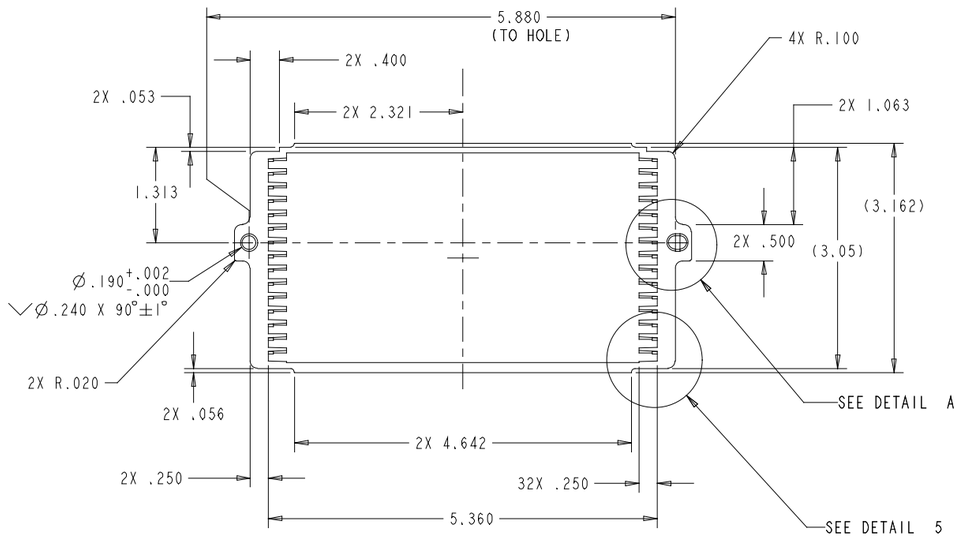
SIZE	CAGE CODE	GIN	DWG NO.	REV
D	07609	-	PAR3-PC1	D
SCALE: 1.500			SHEET 2 OF 2	

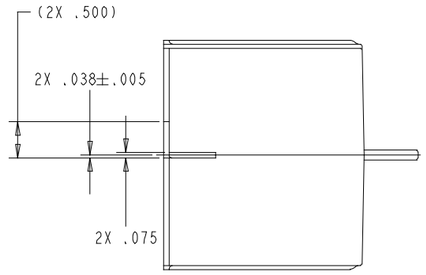
DWG NO.	PAR3-PC2	SH	1	REV	A

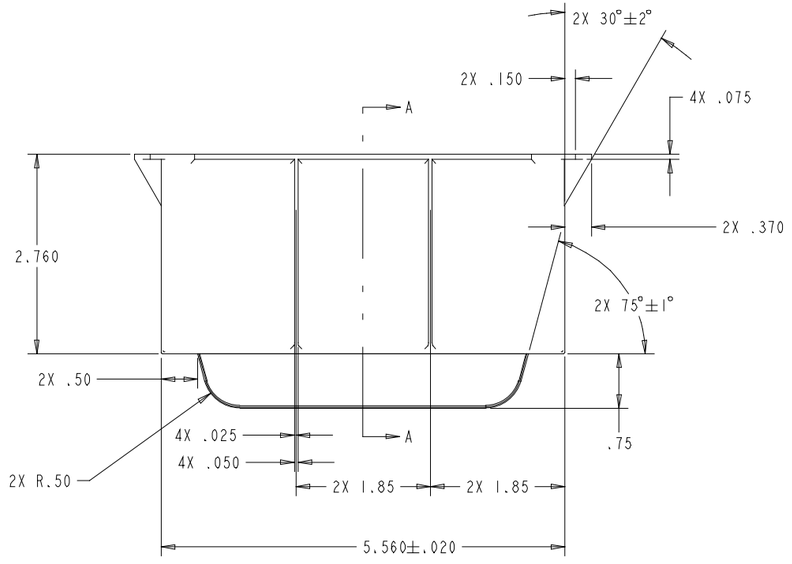
REVISIONS

LTR	DESCRIPTION	DATE	APPROVAL

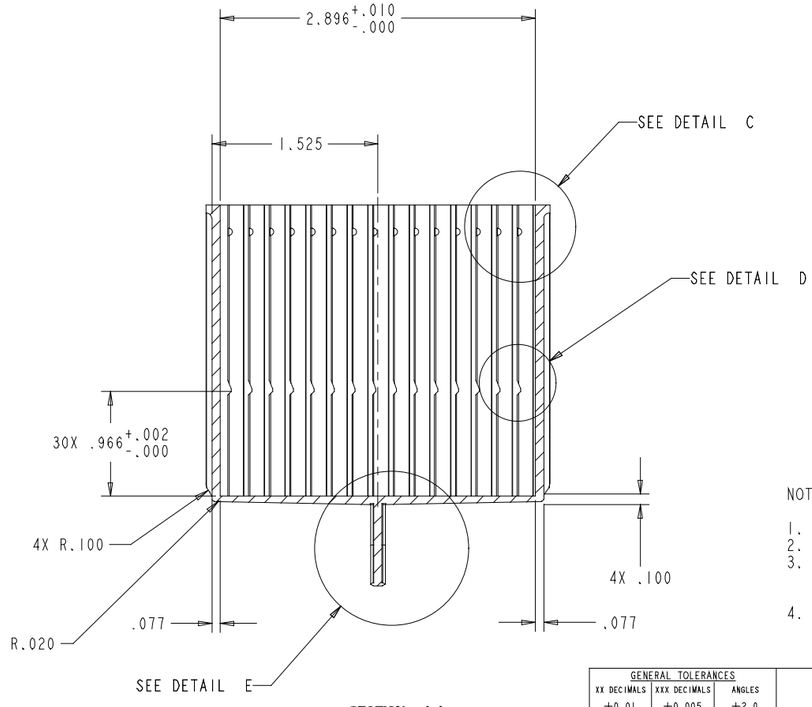
CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY







SECTION A-A
SCALE 1.5



NOTES:

1. REMOVE ALL FLASH
2. MATERIAL: LEXAN HF-1140-701
3. FLAT SURFACES TO HAVE FLATNESS TOLERANCE OF .005 AND NOT TO EXCEED .020 IN OVER ENTIRE LENGTH OF PART.
4. UNSPECIFIED RADII .02±.01

GENERAL TOLERANCES		
XX DECIMALS	XXX DECIMALS	ANGLES
±0.01	±0.005	±2.0

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
REMOVE BURRS AND BREAK SHARP EDGES .015 MAX
INSIDE CORNERS R .015 MAX
SURFACE FINISH 125

MATERIAL:

NEXT ASSY | USED ON
APPLICATION

DO NOT SCALE THIS DRAWING

CHECKED
DRAWN 17-Jul-02
APPROVED FOR NAVSEA DATE

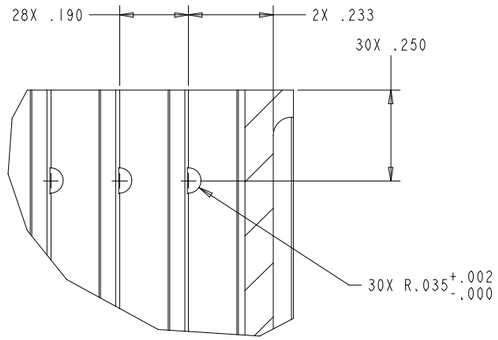
ACS DEFENSE INC.
5290 SHAWNEE ROAD
ALEXANDRIA VA 22312

BOX, CARRIER

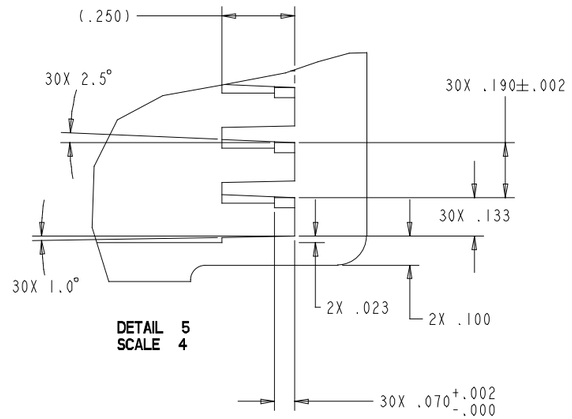
SIZE	CAGE CODE	GIN	DWG NO.	REV
D	07609	-	PAR3-PC2	A

SCALE: 1.000 | WEIGHT: | SHEET 1 OF 2

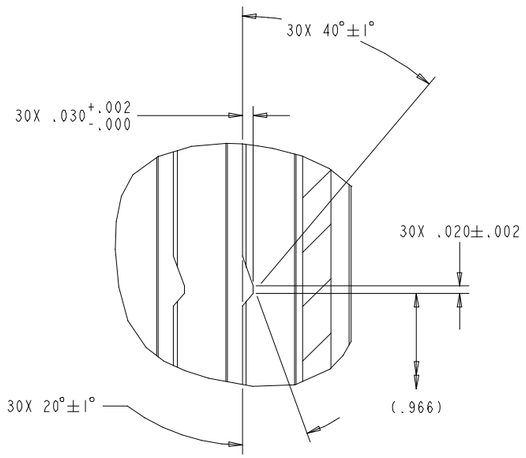
PROE DRAWING: PAR3-PC2 PROE MODEL: BOX A.0



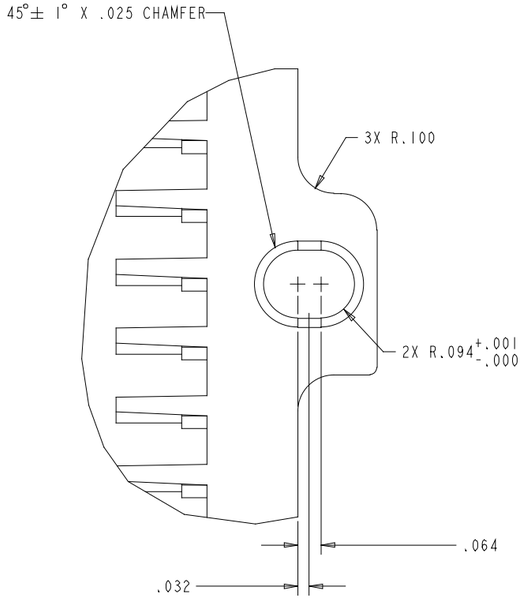
DETAIL C
SCALE 5



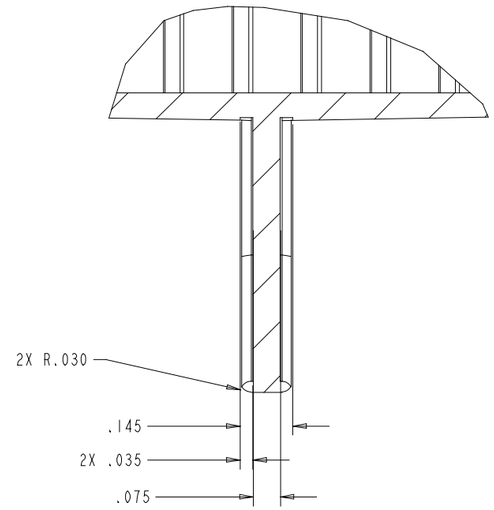
DETAIL 5
SCALE 4



DETAIL D
SCALE 5



DETAIL A
SCALE 5



DETAIL E
SCALE 5

SIZE	CAGE CODE	GIN	DWG NO.	REV
D	07609	-	PAR3-PC2	A
SCALE: 1.000			SHEET 2 OF 2	

DWG NO.	PAR-ASSAY	SH 1	REV -

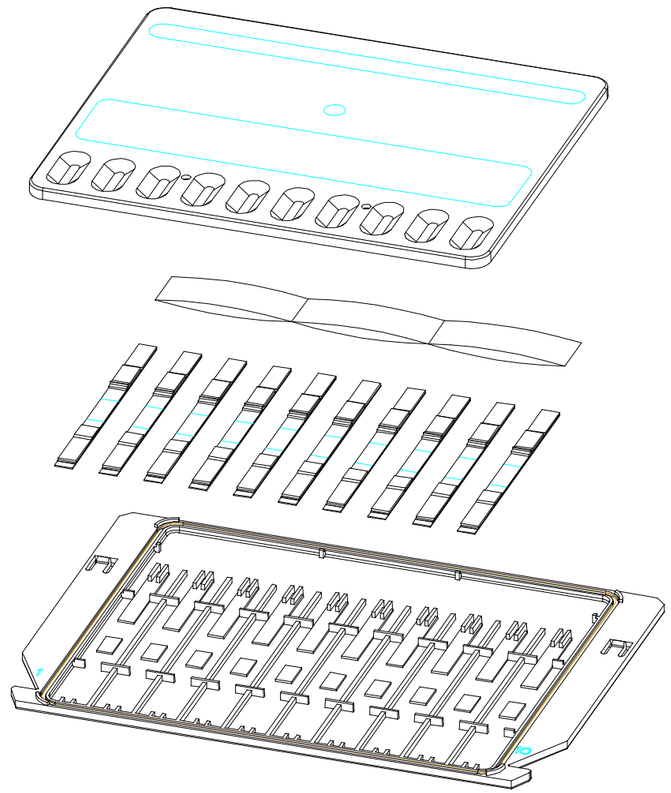
CAD MAINTAINED. CHANGES SHALL BE INCORPORATED BY THE DESIGN ACTIVITY

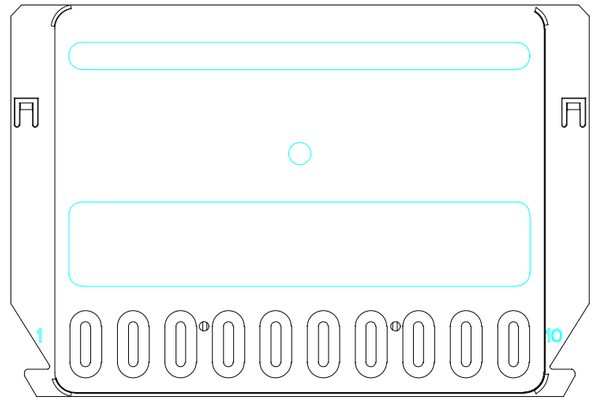
REVISIONS

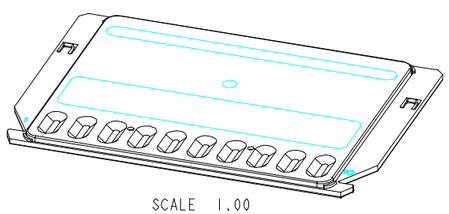
LTR	DESCRIPTION	DATE	APPROVAL

NOTES:

1. ORIENTATION OF FN1 (STRIPS) IS CRITICAL. MAKE SURE YELLOW LINE ON STRIP IS AWAY FROM WELL OF FN4 (TOP).







SCALE 1.00

FIND NO.	QTY REQD	CAGE CODE	PART NO.	NOMACLATURE OR DESCRIPTION	MATERIAL OR NOTE
4	1		PAR3-PC3	TOP, ASSAY	
3	1		02-01909CG01	STRIPPAX DESICCANT	
2	1		PAR3-PC1	BOTTOM, ASSAY	
1	10	07609	AS526-9351	ASSAY STRIP ASSEMBLY	

PARTS LIST

GENERAL TOLERANCES		
XX DECIMALS	XXX DECIMALS	ANGLES
±0.01	±0.005	±2.0

UNLESS OTHERWISE SPECIFIED:
DIMENSIONS ARE IN INCHES
REMOVE BURRS AND BREAK SHARP EDGES .015 MAX
INSIDE CORNERS R .015 MAX
SURFACE FINISH 125

MATERIAL:

DO NOT SCALE THIS DRAWING

NAVAL SURFACE WARFARE CENTER
DAHLGREN DIVISION
17320 DAHLGREN RD
DAHLGREN, VA 22448-5100

CHECKED		
DRAWN	KHR	28-Feb-03
APPROVED FOR NAVSEA		DATE

DEPARTMENT OF THE NAVY

PAR ASSAY CARTRIDGE

SIZE	CAGE CODE	GIN	DWG NO.	REV
D	07609	-	PAR-ASSAY	-

SCALE: 1.500 | WEIGHT: | SHEET 1 OF 1

	SK526-9699
NEXT ASSY	USED ON
APPLICATION	

PROE DRAWING: PAR-ASSAY PROE MODEL: PAR-ASSAY PDMREV

NOT APPLICABLE TO INTERPLANT SHIPMENTS (A)

SPECIAL PACKAGING INSTRUCTION(SPI)

NATIONAL STOCK NUMBER 6665–01–521–7871

NOMENCLATURE	UI	QUP	SPI NUMBER (PN)
PAR CARRIER ASSEMBLY OPERATIONAL	BX(C)	20(C)	PJPOPAR–10

Cleaning & Drying shall be in accordance with MIL–STD–2073–1

MILITARY PRESERVATION REQUIREMENT (MIL–STD–2073–1, Method **41**	STEPS	DRAWING OR SPECIFICATION	STYLE	TYPE	GRADE	CLASS	SIZE AND REMARKS (INCHES)
Cushioning	(D) 1	A–A–59135			A	1	12 x 20 x 1/8 Thick (20 Rqd)
Container	(E) 2	MIL–DTL–117	1	I		E	9 x 14 (20 Rqd)
Dessicant	(F) 3	MIL–D–3464					Two (2) Units (x 20 Rqd)
Closure	(G) 4						Heat Seal (20 Rqd)
Supplemental Container	(H) 5	ASTM D 5118	RSC	CF	W5c	WR	8 x 6 x 4 ID (20 Rqd)
Supplemental Closure	(I) 6	ASTM D 1974					Sealing MethodA (x 20 Rqd)
Supplemental Container 2	(J) 7	ASTM D 5118	RSC	CF	W5c	WR	32 x 17 x 9 1/2 ID
Supplemental Closure 2	(K) 8	ASTM D 1974					Sealing Method A
Cooler Top	(L)(P) 9						See page 7 sketch 6 for assembly of cooler
Cooler Bottom	(M)(P) 10						See page 7 sketch 6 for assembly of cooler
Cooler End	(N)(P) 11						See page 7 sketch 6 for assembly of cooler
Cooler Side	(O)((P) 12						See page 7 sketch 6 for assembly of cooler
Exterior Container	(Q)13	ASTM D 6251	I	III		2	37 x 22 x 15 ID
Exterior Container Closure	(Q)14						
Strapping and Seals	(Q) 15						

INTERMEDIATE PACKAGING AND PACKING
- ☐ In accordance with MIL–STD–2073–1
- ☒ As specified hereon. **(Q) (R) (S)**

MARKING
- ☒ In accordance with MIL–STD–129 and note **(T) (U)**
- ☐ As specified hereon.

QUALITY PERFORMANCE and TESTING REQUIREMENTS
- ☒ In accordance with MIL–STD–2073–1 and Notes **(V) (W) (X)**
- ☐ As specified hereon

Unless otherwise specified, materials shall be minimum size in accordance with MIL–STD–2073–1. Tolerances shall be in accordance with material specifications.

UNIT PACK LOGISTICS DATA (Approximate unit pack weight and size)

Level	WEIGHT (POUNDS)	CUBE (CUBIC FEET)	SIZE (EXTERIOR FEET)
A	28.6 lbs.	8.922 cu. ft.	3.18 x 1.99 x 1.41
B	21.7 lbs.	7.398 cu. ft.	3.10 x 1.85 x 1.29

(A) – This SPI is not applicable for Interplant shipments. Packaging and marking for interplant shipment is for supplies and materials that do not directly enter the military supply system. Typical interplant shipments are shipments from a vendor to a subcontractor or a prime contractor, or between contractors and subcontractors, or from a vendor or contractor to a military arsenal, plant, or other activity for evaluation, immediate use, or further processing as specified in the applicable contract.

Original Preparer: Dean Hansen 19 Nov 2004

Revised by: Dean Hansen *Date: 8 Nov 2005*

ITEM DATA (APPROX)
ITEM CODE – **??????????????**
ITEM SIZE – 6 3/8 x 4 1/2 x 3 1/8 inches Each Carrier
ITEM WEIGHT – .30 lbs

ECBC 81361
AMSRD–ECB–ENA–P

PAGE NUMBER 1 | NUMBER OF PAGES 13

DRAFT DEC 5 2005

APPROVAL	REVISION	DATE

DISTRIBUTION STATEMENT A: Approved for public release, distribution unlimited.

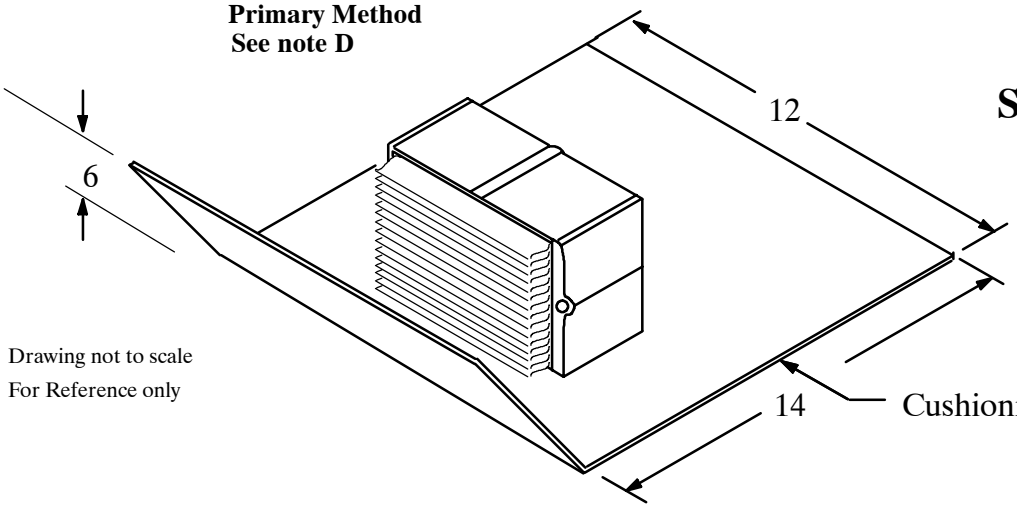
(B) – The components, that make up the Operational PAR Carrier Assembly, Drawing Number JPO-PAR–10 shall as specified on drawing JPOAR–10.

(C) – The unit of issue is box. The unit of measure for this unit pack is 20 Operational PAR Carrier Assemblies per unit pack container.

(D) – Start the wrap by covering the open face of the each carrier box with one 12 inch wide end of the cushioning material parallel to the top or bottom of the open face, and wrap to obtain a maximum number of cushioning layers across the open face (See sketch 1 on page 2) Ensure that corners of wrapped item are securely taped. Secure the wrap with tape conforming to Type I, class 1 or 2 of ASTM D 5486. Tape shall not contact item. As an alternate cushioning the above specified cushioning may be formed into a foam pouch with a 6 inch pocket with an overall dimension of 10 x 24 x 1/8 inch thick material. Secure wrap as required with tape conforming to Type I, class 1 or 2 of ASTM D 5486. Tape shall not contact item.

PLACEMENT OF CARRIER ASSEMBLY IN CUSHIONING

Primary Method
See note D



SKETCH 1

Drawing not to scale
For Reference only

(E) – Place each of the cushioned and taped carrier assemblies in their bag (step 2).

(F) – Desiccant (step 3) shall be placed in each of the barrier bags (step 2 of this SPI).

(G) – Closure of each of the barrier bags shall be accomplished by heat sealing. Heat sealing shall be accomplished in accordance with the barrier bag manufactures instructions. Excess air shall be removed from the barrier bag prior to heat sealing.

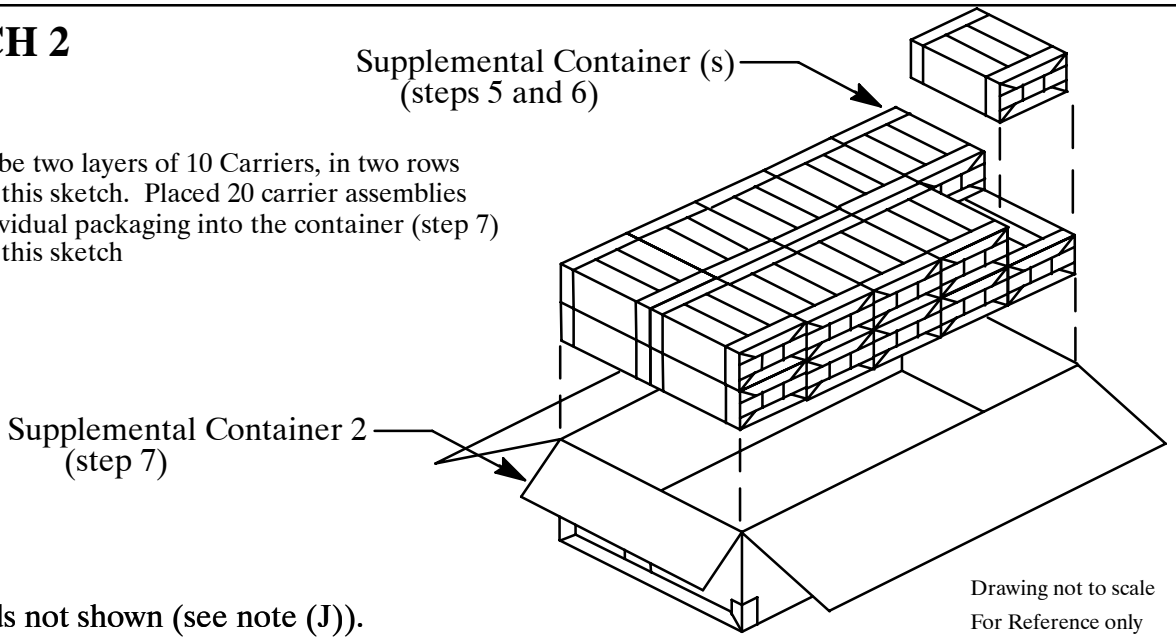
(H) – Place each of the bagged and cushioned carrier assemblies into the supplemental container step 5 of this SPI. Staples shall not be used for the assembly of the supplemental container.

(I) – The closure of the supplemental containers shall be in accordance with step 6 of this SPI. Staples shall not be used for assembly pr closure of the supplemental container.

(J) – Assemble the supplemental containers steps 5 and 6 into the 2nd supplemental container step 7 see sketch 2, Below. Apply fiberboard pads in accordance with ASTM D Type CF, Class WR, Grade any, Variety SW size 31 x 9 (Length wise) or 16 x 9 (end wise) or 30 x 15 (top or Bottom wise) as required to restrict movement of the items within the container. If the items within the pack are restricted from movement the pads may not be required.

SKETCH 2

There shall be two layers of 10 Carriers, in two rows as shown in this sketch. Placed 20 carrier assemblies in their individual packaging into the container (step 7) as shown in this sketch



Filler Pads not shown (see note (J)).

Drawing not to scale
For Reference only

(K) – The closure of the 2nd supplemental container shall be in accordance with step 8 of this SPI. Staples shall not be used for assembly or closure of the supplemental container.

(L) – Fabricate the cooler top as shown on page 4 of this SPI. See step 9.

(M) – Fabricate the cooler bottom as shown on page 5 of this SPI. See step 10.

(N) – Fabricate the cooler end as shown on page 5 of this SPI. See step 11.

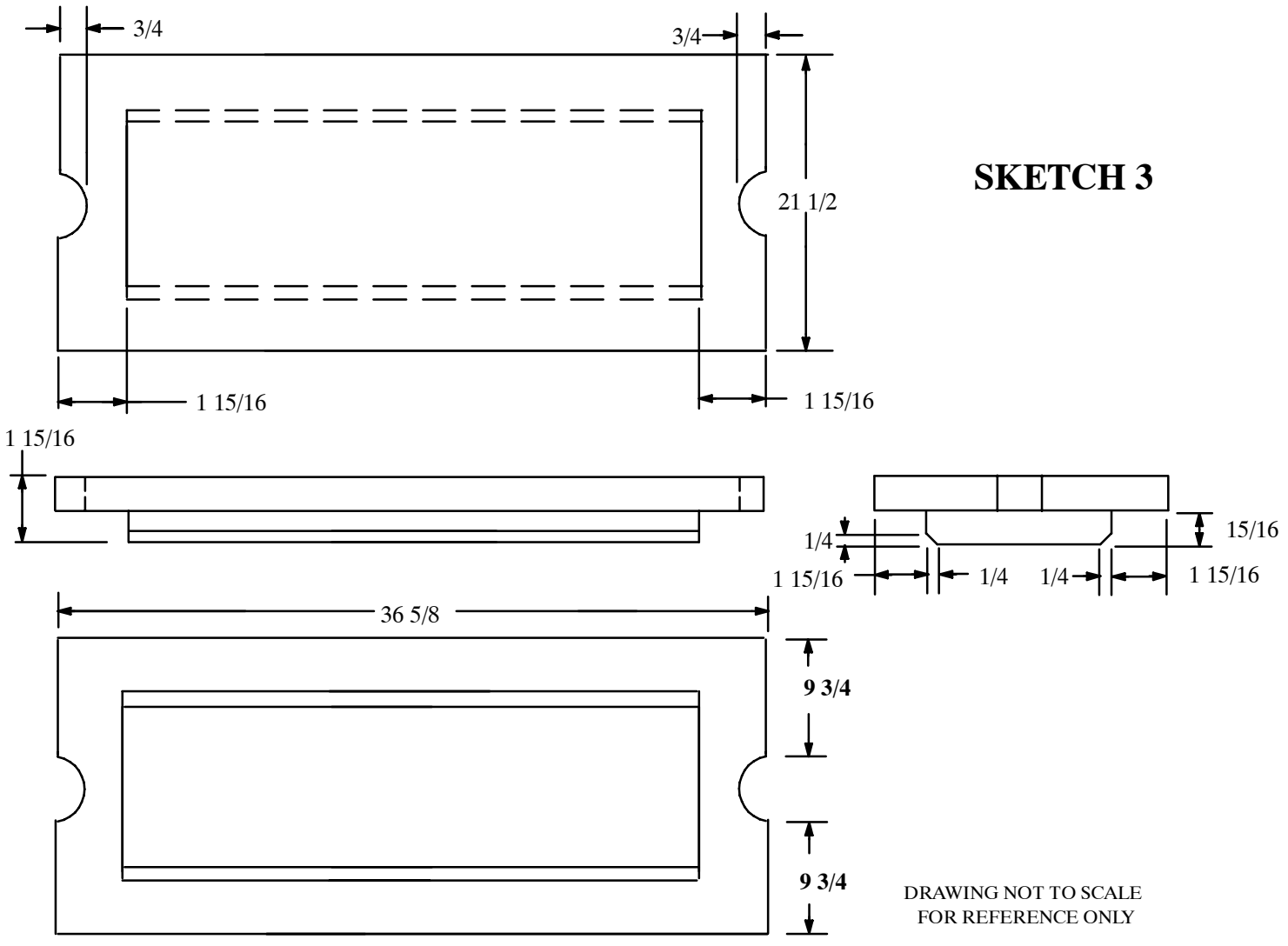
(O) – Fabricate the cooler Sides as shown on page 6 of this SPI. See step 12.

(P) – Polystyrene material used in the cooler pack. Material used for the intermediate cooler pack shall be 1.8 to 2.2 lbs density per cubic foot Polystyrene . The cooler pack shall be assembled in accordance with the sketch on page 6 of this SPI. The R or thermal value of the material used for the cooler pack shall be not less than 4.3 R–Value per 1 inch thickness of material. The standard tolerance for material shall be (+–) .09 inches. Suggested source of supply for the Polystyrene components of this pack

is: FPM Expandable Polystyrene, 2053 Commerce Street, Lancaster, Ohio 43130, Phone number (740) 687–5934.

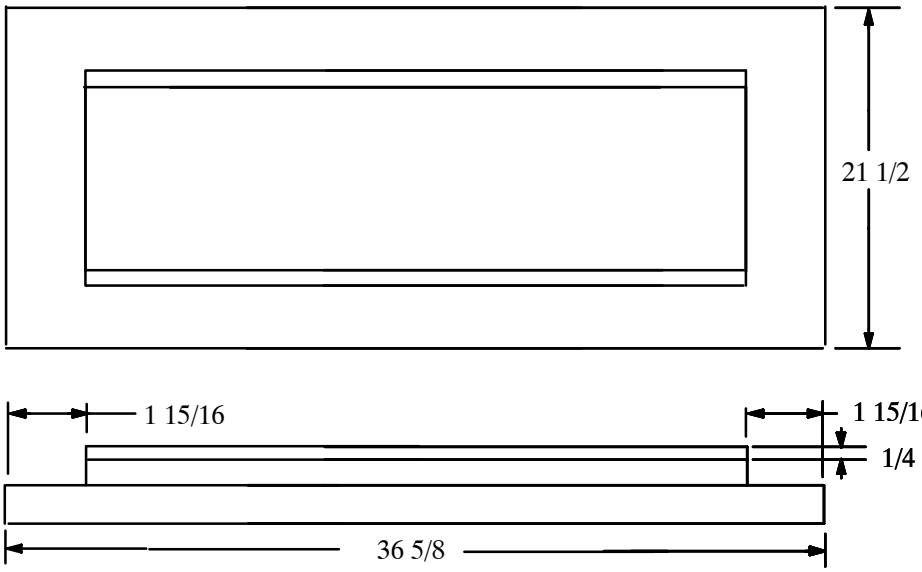
COOLER TOP

(1 Required)



SKETCH 3

DRAWING NOT TO SCALE
FOR REFERENCE ONLY

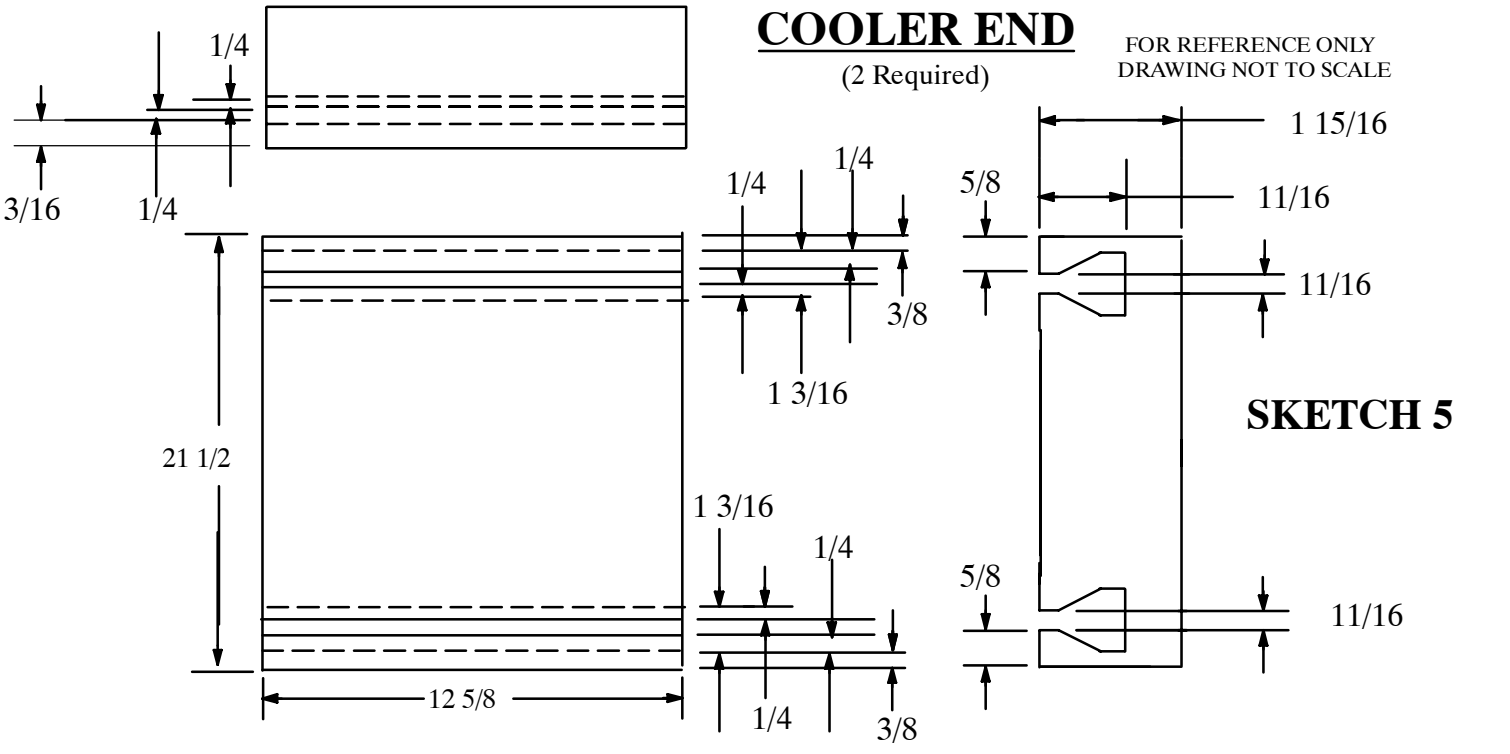


COOLER BOTTOM

(1 Required)

SKETCH 4

DRAWING NOT TO SCALE
FOR REFERENCE ONLY



COOLER END

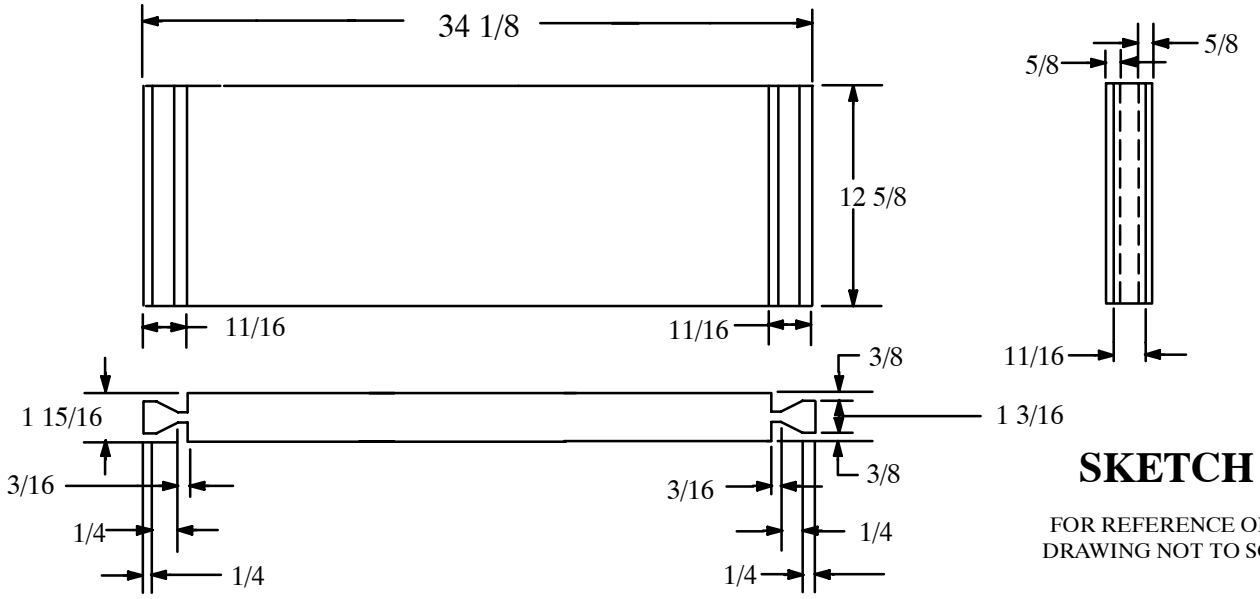
(2 Required)

FOR REFERENCE ONLY
DRAWING NOT TO SCALE

SKETCH 5

COOLER SIDE

(2 Required)

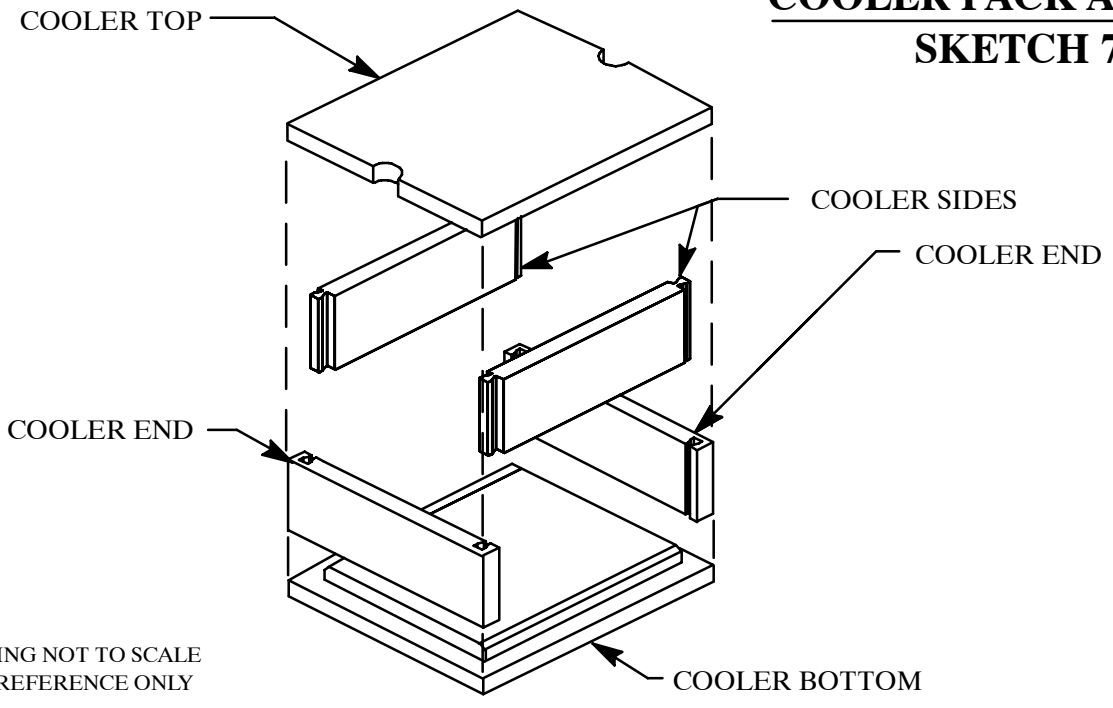


SKETCH 6

FOR REFERENCE ONLY
DRAWING NOT TO SCALE

COOLER PACK ASSEMBLY

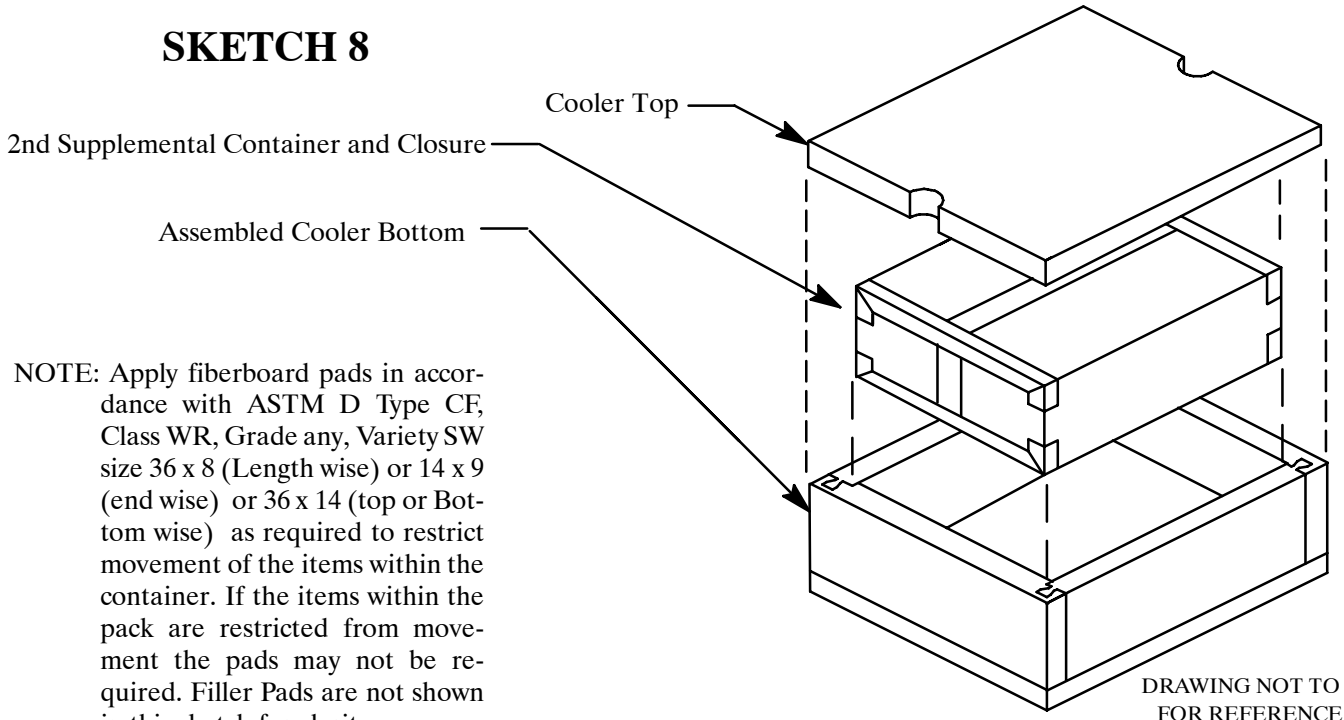
SKETCH 7



DRAWING NOT TO SCALE
FOR REFERENCE ONLY

PLACEMENT OF THE PACKED 2nd SUPPLEMENTAL CONTAINER IN THE COOLER

SKETCH 8

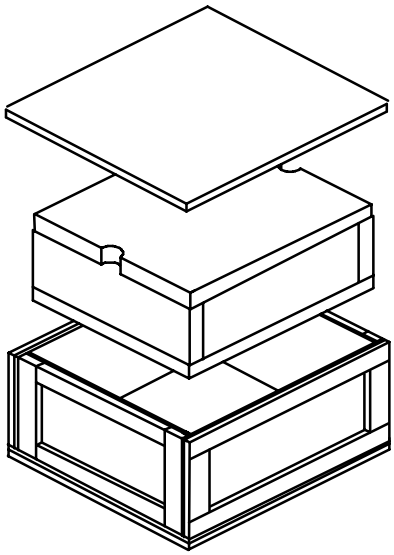


NOTE: Apply fiberboard pads in accordance with ASTM D Type CF, Class WR, Grade any, Variety SW size 36 x 8 (Length wise) or 14 x 9 (end wise) or 36 x 14 (top or Bottom wise) as required to restrict movement of the items within the container. If the items within the pack are restricted from movement the pads may not be required. Filler Pads are not shown in this sketch for clarity.

DRAWING NOT TO SCALE
FOR REFERENCE ONLY

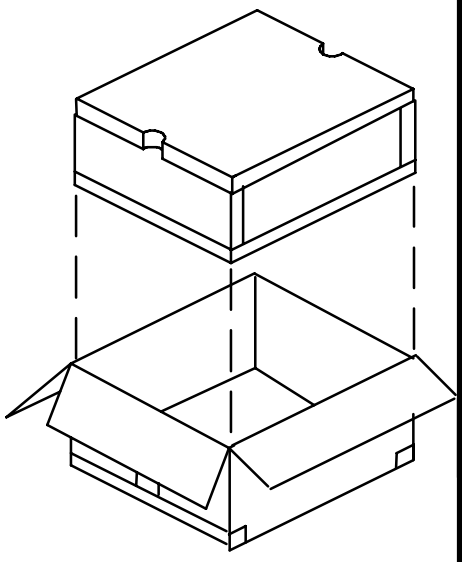
COOLER PACK PLACEMENT IN EXTERIOR CONTAINER

SKETCH 9



LEVEL A EXTERIOR CONTAINER

NOTE: Apply fiberboard pads in accordance with ASTM D Type CF, Class WR, Grade any, Variety SW size 35 x 14 (Length wise) or 20 x 14 (end wise) or 35 x 20 (top or Bottom wise) as required to restrict movement of the items within the container. If the items within the pack are restricted from movement the pads may not be required. Filler Pads are not shown in this sketch for clarity.



LEVEL B EXTERIOR CONTAINER

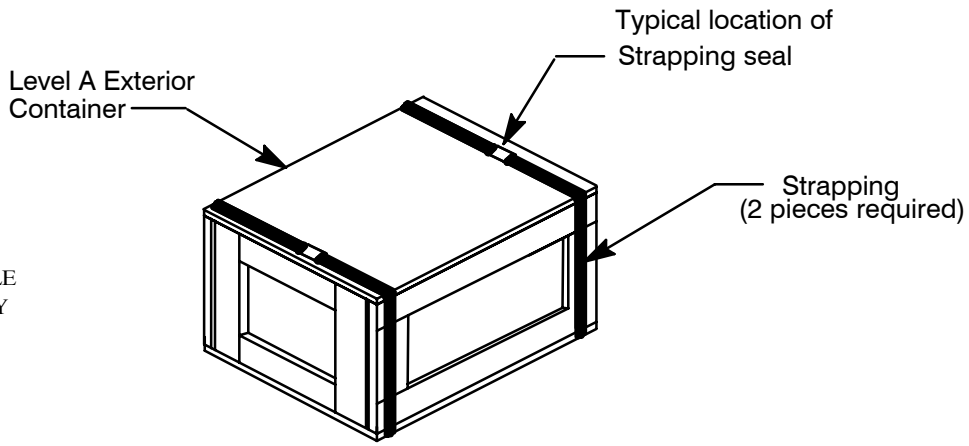
FOR REFERENCE ONLY
DRAWING NOT TO SCALE

(Q) – Exterior Shipping Container. This SPI offers two levels of exterior shipping container. Level A Shall be used for overseas shipments and the B exterior shipping container may be used for domestic shipments only (see page 7, Sketch 9).

Level A, Exterior shipping container Twenty (20) carrier assemblies shall be assembled into the cooler pack as shown on page 7 of this SPI. The cooler pack shall then be placed in the exterior shipping container in accordance with the sketch on page 7 of this SPI. The Level A exterior shipping container shall be a Style I, Class 2, Type III (Plywood only), Treatment A, cleated plywood box size 37 x 22 x 15 ID inches in accordance with ASTM D 6251. All paneling for the container shall be fabricated of plywood conforming to PS–1. Thickness of the plywood panels shall be a minimum of 3/16 inch. Oriented Strand Board (OSD) shall not be used.

Level A, Exterior shipping container closure. Closure shall be with 6 penny box coated nails.

STRAPPING OF LEVEL A EXTERIOR CONTAINER



DRAWING NOT TO SCALE
FOR REFERENCE ONLY

Strapping of the Level A Shipping Container. Flat steel strapping shall be applied to the unit pack container as shown in the sketch above. Two straps are required. The strapping shall be placed on the Battens as shown in the sketch above. Strapping shall be Type 1, Heavy Duty, Finish B, Grade 2, minimum 3/8 inches in width x 0.012 inches in thickness length as required. The metal seals shall be of the correct size, Heavy duty, Finish B, Grade 2, Style any. Both strapping and seals shall be in accordance with ASTM D 3953. Once tensioned, the steel strappings shall be secured with metal seals of the correct size to effect a strong closure.

Level B, Exterior shipping container. Twenty (20) carrier assemblies shall be assembled into the cooler pack as shown on page 7 of this SPI. The cooler pack shall then be placed in the exterior shipping container in accordance with the sketch on page 7 of this SPI. The Level B exterior shipping container shall be a RSC, Class WR, Grade V3c, Variety SW, Type CF, Fiberboard container size 37 x 22 x 15 inches ID in accordance with ASTM D 5118.

Level B, Exterior shipping container closure. The closure of the Level B exterior shipping container shall be sealing method B of ASTM D 1974. Type V, tape in accordance with ASTM D 5486 shall be used.

(R) – The exterior shipping container specified in note (Q) shall serve as the exterior shipping container no intermediate shipping is required.

(S) – When shipping the carrier assemblies from the Manufacture to the depot they shall be shipped under active Temperature controls as specified in the contract.

(T) – In addition to the marking requirements of MIL–STD–129 the following markings shall be applied to the supplemental container step 5:

a. Pack Date
b. Expiration Date
c. Lot Number
d. Shelf Life Markings
e. Special Marking:

. "**Keep From Freezing, Keep from heat over 90 Degrees F.**"

Additional Special Markings The following additional markings shall be applied to the exterior shipping container only:

a. Pack Date
b. Expiration Date
c. Lot Number
d. Shelf Life Markings
e. Special Marking

"PROTECT FROM FREEZING
TEMPERATURE SENSITIVE MATERIAL
EXPEDITE SHIPMENT AND MOVEMENT
APPLY TEMPERATURE CONTROL AT FINAL DESTINATION"

The additional special markings as shown in (T) e. above shall be marked in red print at least 48 print and placed on the marking side of the exterior shipping container. If there is not enough room on the marking side of the container. The label shall then be placed on top of the exterior shipping container.

(U) – In addition to the marking requirements found in note (T) apply one self adhering Temperature sensitive label on the marking surface of each inner barrier bag (step 2 of this SPI) and apply one self adhering Temperature sensitive label on the marking surface on each of the 20 outer barrier containers and (steps 4 of this SPI). Insure that the Temperature sensitive label does not cover any of the markings as required in note (T). The label shall be model, TL–S–140, manufactured by OMEGA Engineering Inc. P O Box 4047, Stamford, CT 06907–0047, Phone number 1–888–846–8865, Fax number (203) 359–7700. Web Site "www.omega.com".

(V) –Barrier (bag) leakage. The barrier bag (step 4) shall show no signs of leakage, as evidenced by a continuous stream of bubbles which appear at any surface when tested in accordance with Part V, 501 of this PQAP

(W) – Heat seal seam. The heat seal seam of the barrier bag (step 4) shall show no sign of heat seam separation when tested in accordance with Part V, 502 of this PQAP.

(X) – Packaging Quality Assurance Provisions (PQAP).

Part I – Applicable Documents

Military standards

MIL–STD–2073–1 – Standard Practice For Military Packaging

MIL–STD–3010 – Department of Defense Test Method Standard Test Procedures for Packaging Materials

Part II – Quality Provisions.

1. First Article Inspection. The first article packaging sample, shall be taken from the sample size of the PAR Carrier Assemblies drawing JPOPAR–10 as specified in the Contract or Quality plan used by the contractor and packaged in accordance with the military preservation requirements as specified in this SPI. The packaging sample size shall be 3 PAR Carrier Assemblies and they shall be packaged in accordance with the military preservation requirements of this SPI. When an item requirement does not exist for a First Article Inspection, a packaging First Article Inspection sample is required. The sample shall consist of 3 PAR Carrier Assemblies and shall be packaged in accordance with the military preservation requirements of this SPI, The First Article Inspection sample shall be submitted for inspection and approval in accordance the terms of the contract. In addition, 3 empty unit pack container (bag), step 4, shall be removed from the lot of bags and subjected to the destructive test in accordance with Part V, 502. The sample of empty bags shall be produced using the same methods, materials, and equipment as will be used during regular production. As determined by the Government, the packaging samples may be subjected to any or all of the examinations and tests specified in this PQAP and be inspected for compliance with any or all of the requirements of this SPI.

a. Acceptance Criteria. If any first article sample fails to comply with any of the requirements, the first article sample shall be rejected. The Government reserves the right to terminate inspection upon any failure to comply with any of the requirements.

2. Conformance Inspection.

a. Lotting. A lot shall consist of the items and packaging produced by one manufacturer, at one plant, from the same materials, under essentially the same manufacturing conditions, and shall not exceed one week's production. **However; when the packaging sample is produced at the same time as the item sample, lotting shall be as specified for the item, except that the items shall be packaged as specified herein.**

b. Sampling. Sampling shall be selected at random. Sampling shall be conducted in accordance with table I using the levels specified in Part III of this PQAP. If required, special sampling, inspection , and acceptance criteria are contained in Part III of this PQAP.

c. Inspection. Inspection shall consist of examination and test of all the characteristics contained in Part III and Part IV of this PQAP.

TABLE I. Sampling

Lot size	Inspection levels and sample sizes										
	I	II	III	IV	V	VI	VII	VIII	IX	X	XI
2 to 8	*	*	*	*	*	*	*	*	5	3	2
9 to 15	*	*	*	*	*	*	13	8	5	3	2
16 to 25	*	*	*	*	*	20	13	8	5	3	3
26 to 50	*	*	*	*	32	20	13	8	5	5	5
51 to 90	*	*	*	50	32	20	13	8	7	6	5
91 to 150	*	*	125	50	32	20	13	12	11	7	6
151 to 280	*	*	125	50	32	20	20	19	13	10	7
281 to 500	*	315	125	50	48	47	29	21	16	11	9
501 to 1200	*	315	125	75	73	47	34	27	19	15	11
1201 to 3200	1250	315	125	116	73	53	42	35	23	18	13
3201 to 10000	1250	315	192	116	86	68	50	38	29	22	15
10001 to 35000	1250	315	294	135	108	77	60	46	35	29	15
35001 to 150000	1250	490	294	170	123	96	74	56	40	29	15
150001 to 500000	1250	715	345	200	156	119	90	64	40	29	15
500001 and over	1250	715	435	244	189	143	102	64	40	29	15

*Indicates one hundred percent inspection. If sample size exceeds lot size, perform one hundred percent inspection Accept the lot represented on zero nonconforming characteristics and reject the lot represented on one or more non–conforming characteristics for all inspection levels.

3. **Inspection equipment coding.**
   CE – Commercial inspection equipment
   VI – Visual inspection

PART III – INSPECTION REQUIREMENTS

CLASSIFICATION OF CHARACTERISTICS

Category	Characteristic	Sampling and acceptance criteria	Inspection method
Critical			
None Defined			
Major:			
None Defined			

	Characteristic	Sampling and acceptance criteria	Inspection method	Category
Minor				
201	Item completely clean and dry prior to unit packaging	VL–VIII	VI	
202	Number and type of components that make up the	VL–VIII	VI	
	Carrier Assemblies evident and correct	VL–VIII	VI	
203	Cushioning (step 1) correct and evident	VL–VIII	VI and CE	
204	Container (step 2) evident and correct	VL–VIII	VI and CE	
205	Desiccant (step 3) evident and correct	VL–VIII	VI and CE	
206	Barrier bag closure (step 4) evident and correct	VL–VIII	VI and CE	
207	Supplemental container (step 5) evident and correct	VL–VIII	VI and CE	

208	Supplemental container closure (step 6) evident and correct	VL–VIII	VI and CE
209	2nd Supplemental container (step 7) evident and correct	VL–VIII	VI and CE
210	2nd Supplemental container closure (step 8) evident and correct	VL–VIII	VI and CE
211	Cooler top (step 9) evident and correct	VL–VIII	VI and CE
212	Cooler bottom (step 10) evident and correct	VL–VIII	VI and CE
213	Cooler end (step 11) evident and correct	VL–VIII	VI and CE
214	Cooler side (step 12) evident and correct	VL–VIII	VI and CE
215	Cooler pack assembly (see page 6) evident and correct	VL–VIII	VI and CE
216	Placement of supplemental containers in assembled cooler pack (see page 7) evident and correct	VL–VIII	VI and CE
217	Exterior container (step 13) evident and correct	VL–VIII	VI and CE
218	Placement of cooler pack within exterior container (see page 7) evident and correct	VL–VIII	VI and CE
219	Closure of exterior container (step 14) evident and correct	VL–VIII	VI and CE
220	Steel Strapping (step 15) evident and correct	VL–VIII	VI and CE
221	Filler Pads (note (J)) (when Required) evident and correct	VL–VIII	VI and CE
222	Filler Pads (Sketch 8)\(when Required) evident and correct	VL–VIII	VI and CE
223	Filler Pads (Sketch 9)\(when Required) evident and correct	VL–VIII	VI and CE
224	Temperature sensitive label (note U) evident and correct	VL–VIII	VI and CE
225	Unit pack container marking evident, correct, and legible	VL–VIII	VI and CE
226	Exterior shipping container marking evident, correct, and legible	VL–VIII	VI and CE
227	Barrier bag leakage.	Part III, 301	Part V, 501
228	Barrier bag heat–seal seam strength.	Part III, 302	Part V, 502

SPECIAL SAMPLING, INSPECTION, AND ACCEPTANCE CRITERIA

301 Barrier bag leakage. Three barrier bags and their contents (step 4), packed for shipment, shall be selected at random from each lot and tested in accordance with Part V, 501 of this PQAP. Failure of any sample to meet the leakage requirement shall be cause for rejection of the lot from which the sample was drawn.

302 Barrier bag heat–seal seam (destructive test). Three empty barrier bags (steps 4) shall be selected at random from those being used for each lot of items and tested in accordance with Part V, 502 of this PQAP. Failure of any sample to meet the seam requirement shall be cause for rejection of the lot from which the sample was drawn.

PART IV – CERTIFICATION REQUIREMENTS Certification shall be required for each characteristic specified below and shall include actual examination and test results when required herein. Results of examinations shall be on file at the contractor's facility and shall be available to the Government for review.

Number	Characteristic	To comply with
401	Packaging material	Applicable specification or standard specified in this SPI.

PART V – TEST METHODS AND PROCEDURES

501 –Container (bag) leakage. The carrier assembly packaged in accordance with step 4 shall not leak when tested in accordance with Test Method, 5009, the Hot Water Technique, of MIL–STD–3010.

502 Heat–seal seam strength. The heat seal seam of the empty barrier bag step 4, shall be tested in accordance with Test Method 2024 of MIL–STD–3010.

NOT APPLICABLE TO INTERPLANT SHIPMENTS (A)

SPECIAL PACKAGING INSTRUCTION(SPI)

NATIONAL STOCK NUMBER 6665–01–521–7870

NOMENCLATURE	UI	QUP	SPI NUMBER (PN)
PAR CARRIER ASSEMBLY, TRAINING	BX(C)	8 (C)	PJPOPAR–20

Cleaning & Drying shall be in accordance with MIL–STD–2073–1

MILITARY PRESERVATION REQUIREMENT (MIL–STD–2073–1, Method 41)	STEPS	DRAWING OR SPECIFICATION	STYLE	TYPE	GRADE	CLASS	SIZE AND REMARKS (INCHES)
Cushioning	(D) 1	A–A–59135			A	1	12 x 20 x 1/8 Thick (8 Rqd)
Container	(E) 2	MIL–DTL–117	1	I		E	9 x 14 (8 Rqd)
Dessicant	(F) 3	MIL–D–3464					Two (2) Units (x 8 Rqd)
Closure	(G) 4						Heat Seal (x 8 Rqd)
Supplemental Container	(H) 5	ASTM D 5118	RSC	CF	W5c	WR	8 x 6 x 4 ID (x Rqd)
Supplemental Closure	(I) 6	ASTM D 1974					Sealing Method A
Supplemental Container 2	(J) 7	ASTM D 5118	RSC	CF	W5c	WR	25 7/8 x 8 3/4 x 9 3/4 ID
Supplemental Closure 2	(K) 8	ASTM D 1974					Sealing Method A
Cooler Top	(L)(P) 9						
Cooler Bottom	(M)(P) 10						
Cooler End	(N)(P) 11						
Cooler Side	(O)((P) 12						
Exterior Container	(Q) 13	ASTM D 6251	I	III		2	29 3/4 x 11 1/2 x 15 ID
Exterior Container Closure	(Q) 14						
Strapping and Seals	(Q) 15						

INTERMEDIATE PACKAGING AND PACKING
- ☐ In accordance with MIL–STD–2073–1
- ☒ As specified hereon. **(Q) (R) (S)**

MARKING
- ☒ In accordance with MIL–STD–129 and notes **(T) (U)**
- ☐ As specified hereon.

QUALITY PERFORMANCE and TESTING REQUIREMENTS
- ☒ In accordance with MIL–STD–2073–1 and Notes **(V) (W) (X)**
- ☐ As specified hereon

Unless otherwise specified, materials shall be minimum size in accordance with MIL–STD–2073–1. Tolerances shall be in accordance with material specifications.

UNIT PACK LOGISTICS DATA (Approximate unit pack weight and size)

Level	WEIGHT (POUNDS)	CUBE (CUBIC FEET)	SIZE (EXTERIOR FEET)
A	12.45	4.421 cu ft	2.67 x 1.15 x 1.44
B	9.94	3.160 cu ft	2.50 x .98 x 1.29

(A) – This SPI is not applicable for Interplant shipments. Packaging and marking for interplant shipment is for supplies and materials that do not directly enter the military supply system. Typical interplant shipments are shipments from a vendor to a subcontractor or a prime contractor, or between contractors and subcontractors, or from a vendor or contractor to a military arsenal, plant, or other activity for evaluation, immediate use, or further processing as specified in the applicable contract.

Original Preparer: Dean Hansen 10 Dec 2003 — *Revised by: Dean Hansen* *Date: 8 Nov 2005*

ITEM DATA (APPROX)
ITEM CODE – ??????????????
ITEM SIZE – 6 3/8 x 4 1/2 x 3 1/8 inches
ITEM WEIGHT – .30 lbs

ECBC 81361
AMSRD–ECB–ENA–P

PAGE NUMBER 1 | NUMBER OF PAGES 13

DRAFT DEC 5 2005

APPROVAL	REVISION	DATE

DISTRIBUTION STATEMENT A: Approved for public release, distribution unlimited.

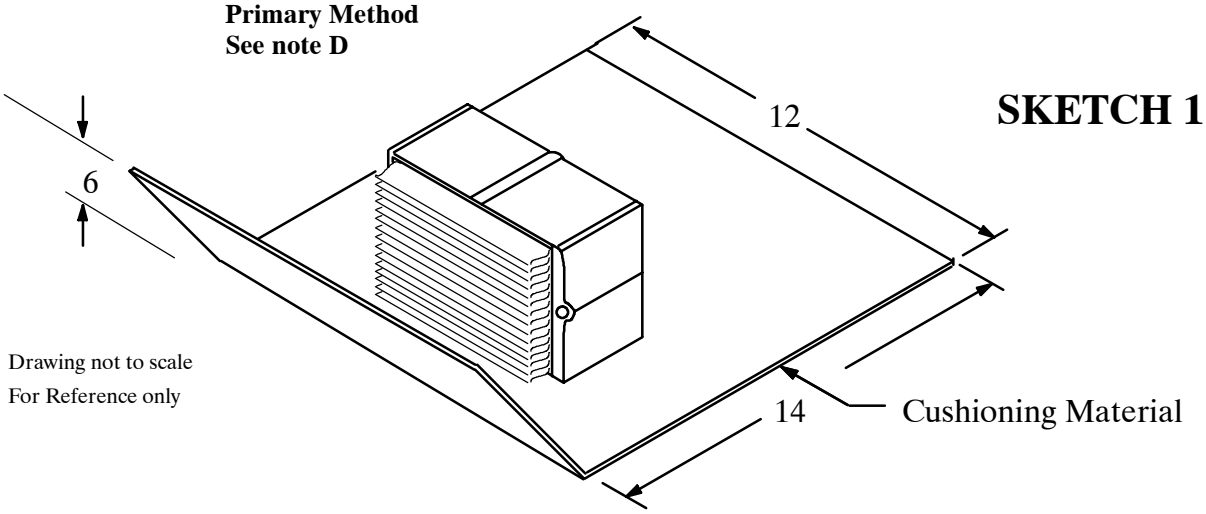
(B) – The components, that make up the PAR Training Carrier Assembly, are as specified on drawing JPO-PAR–20.

(C) – The unit of issue is box. The unit of measure for this pack is 8 PAR Training Carrier Assemblies per unit pack container.

(D) – Start the wrap by covering the open face of the each carrier box with one 12 inch wide end of the cushioning material parallel to the top or bottom of the open face, and wrap to obtain a maximum number of cushioning layers across the open face (See sketch 1 on page 2) Ensure that corners of wrapped item are securely taped. Secure the wrap with tape conforming to Type I, class 1 or 2 of ASTM D 5486. Tape shall not contact item. As an alternate cushioning the above specified cushioning may be formed into a foam pouch with a 6 inch pocket with an overall dimension of 10 x 24 x 1/8 inch thick material. Secure wrap as required with tape conforming to Type I, class 1 or 2 of ASTM D 5486. Tape shall not contact item.

PLACEMENT OF CARRIER ASSEMBLY IN CUSHIONING

Primary Method
See note D



SKETCH 1

Drawing not to scale
For Reference only

(E) – Place each of the cushioned and taped carrier assemblies in their bag (step 2).

(F) – Desiccant (step 3) shall be placed in each of the barrier bags (step 2 of this SPI).

(G) – Closure of each of the barrier bags shall be accomplished by heat sealing. Closure of the barrier bag shall be accomplished by heat sealing. Heat sealing shall be accomplished in accordance with the barrier bag manufactures instructions. Excess air shall be removed from the barrier bag prior to heat sealing.

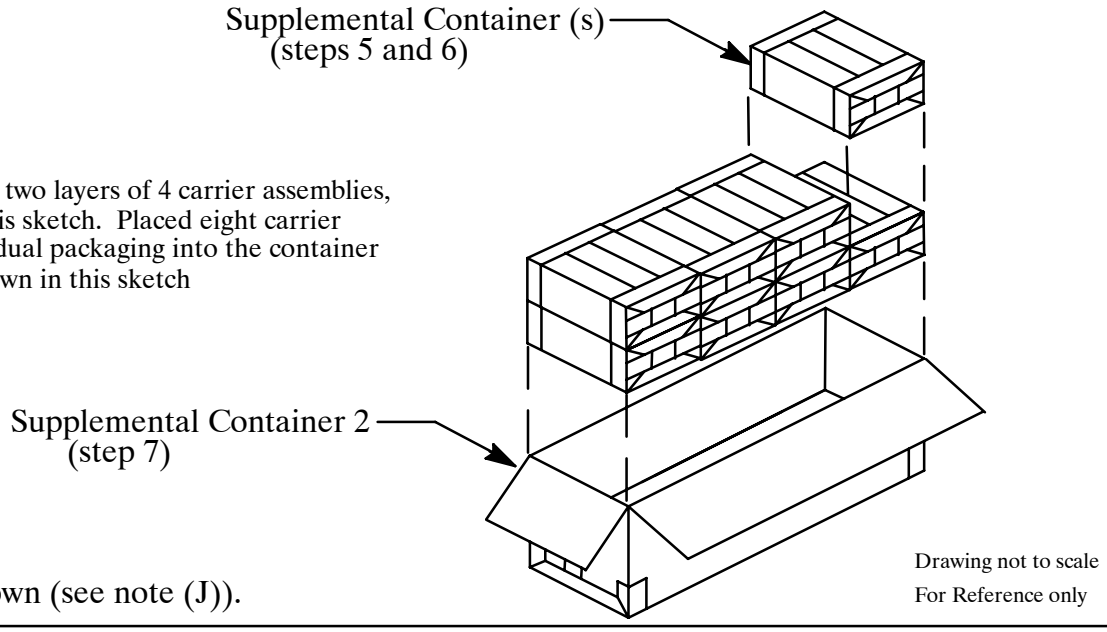
(H) – Place each of the bagged and cushioned carrier assemblies into the supplemental container step 5 of this SPI. Staples shall not be used for the assembly of the supplemental container.

(I) – The closure of the supplemental container shall be in accordance with step 6 of this SPI. Staples shall not be used for the assembly or closure of the supplemental container.

(J) – Assemble the supplemental containers steps 5 and 6 into the 2nd supplemental container step 7 see sketch 2, Below. Apply fiberboard pads in accordance with ASTM D Type CF, Class WR, Grade any, Variety SW size 25 x 9 (Length wise) or 8 x 9 (end wise) or 25 x 8 (top or Bottom wise) as required to restrict movement of the items within the container. If the items within the pack are restricted from movement the pads may not be required.

SKETCH 2

There shall be two layers of 4 carrier assemblies, as shown in this sketch. Placed eight carrier in their individual packaging into the container (step 7) as shown in this sketch



Filler Pads not shown (see note (J)).

Drawing not to scale
For Reference only

(K) – The closure of the 2nd supplemental container shall be in accordance with step 8 of this SPI. Staples shall not be used for the assembly or closure of the supplemental container.

(L) – Fabricate the cooler top as shown on page 4 of this SPI. See step 9.

(M) – Fabricate the cooler bottom as shown on page 5 of this SPI. See step 10.

(N) – Fabricate the cooler end as shown on page 5 of this SPI. See step 11.

(O) – Fabricate the cooler Sides as shown on page 6 of this SPI. See step 12.

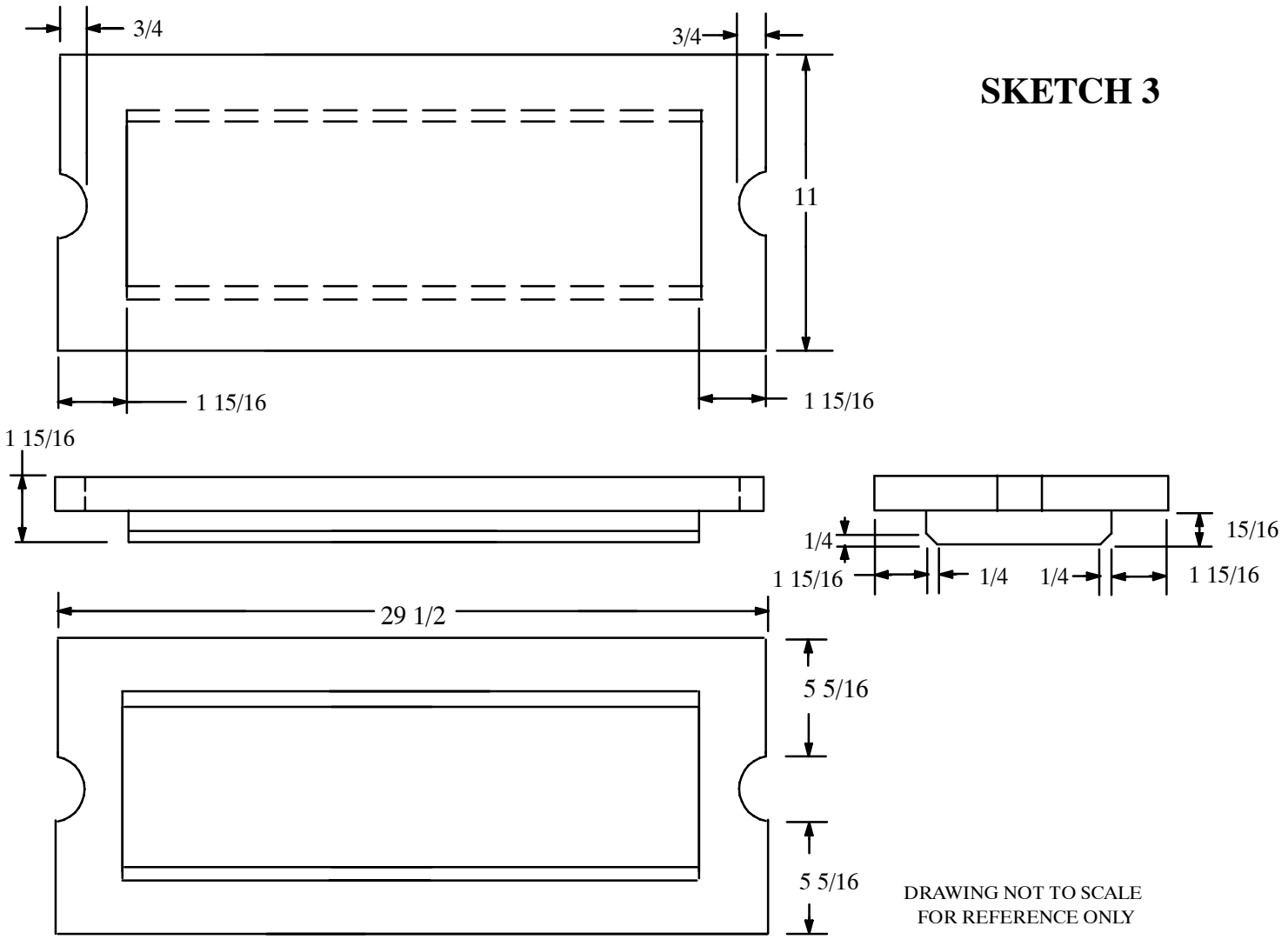
(P) – Polystyrene material used in the cooler pack. Material used for the intermediate cooler pack shall be 1.8 to 2.2 lbs density per cubic foot Polystyrene. The cooler pack shall be assembled in accordance with the sketch on page 6 of this SPI. The R or thermal value of the material used for the cooler pack shall be not less than 4.3 R–Value per 1 inch thickness of material. The standard tolerance for material shall be (+–) .09 inches. Suggested source of supply for the Polystyrene components of this pack

is: FPM Expandable Polystyrene, 2053 Commerce Street, Lancaster, Ohio 43130, Phone number (740) 687–5934.

COOLER TOP

(1 Required)

SKETCH 3



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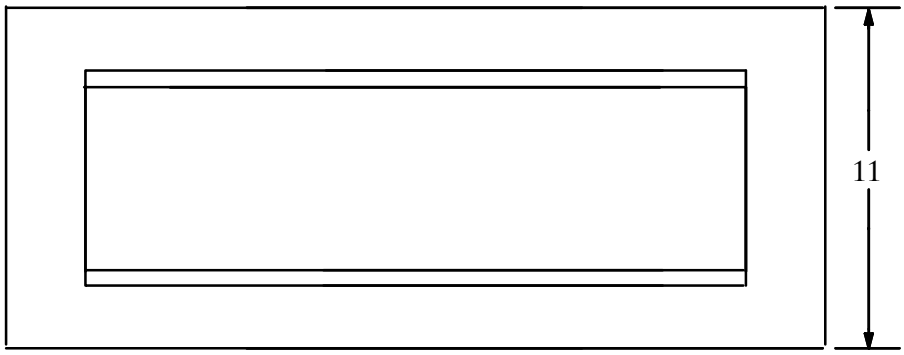
FOR REFERENCE ONLY

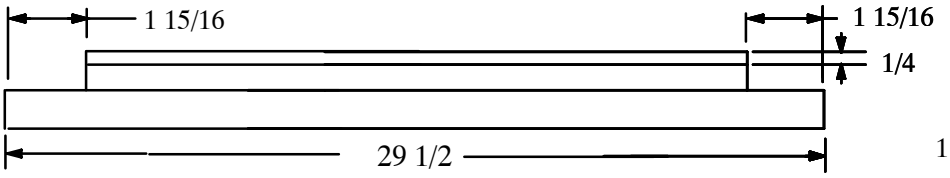


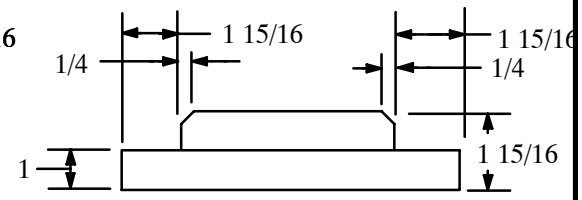
COOLER BOTTOM

(1 Required)

SKETCH 4

DRAWING NOT TO SCALE
FOR REFERENCE ONLY





COOLER END

(2 Required)

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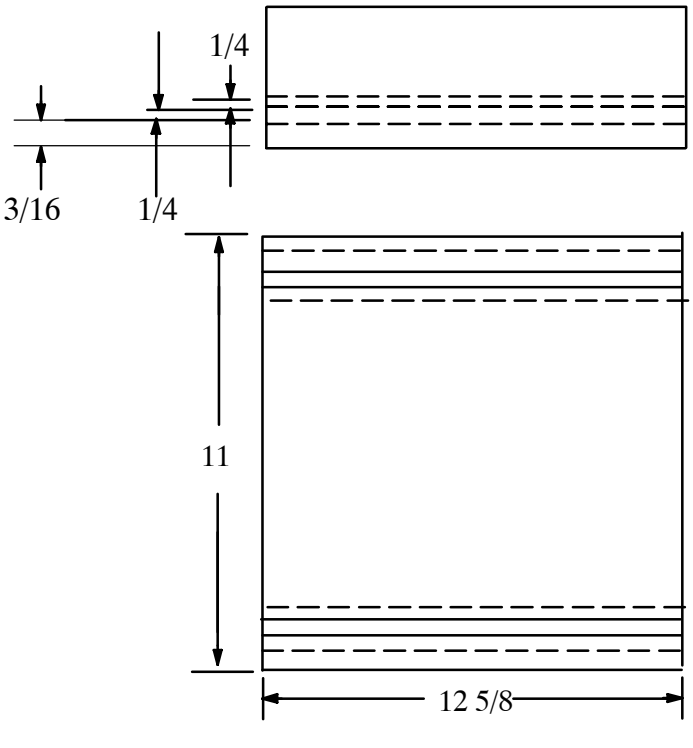
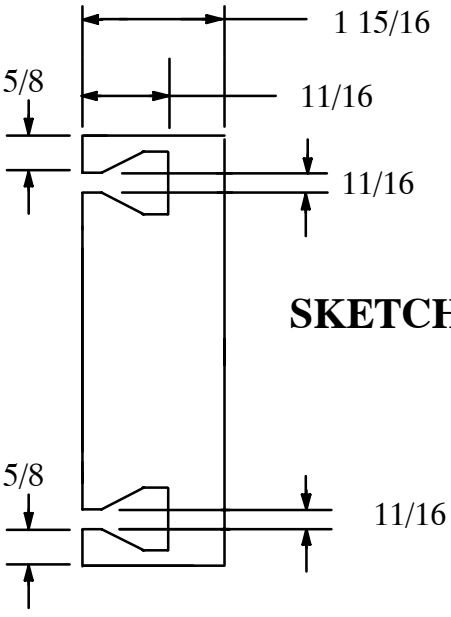
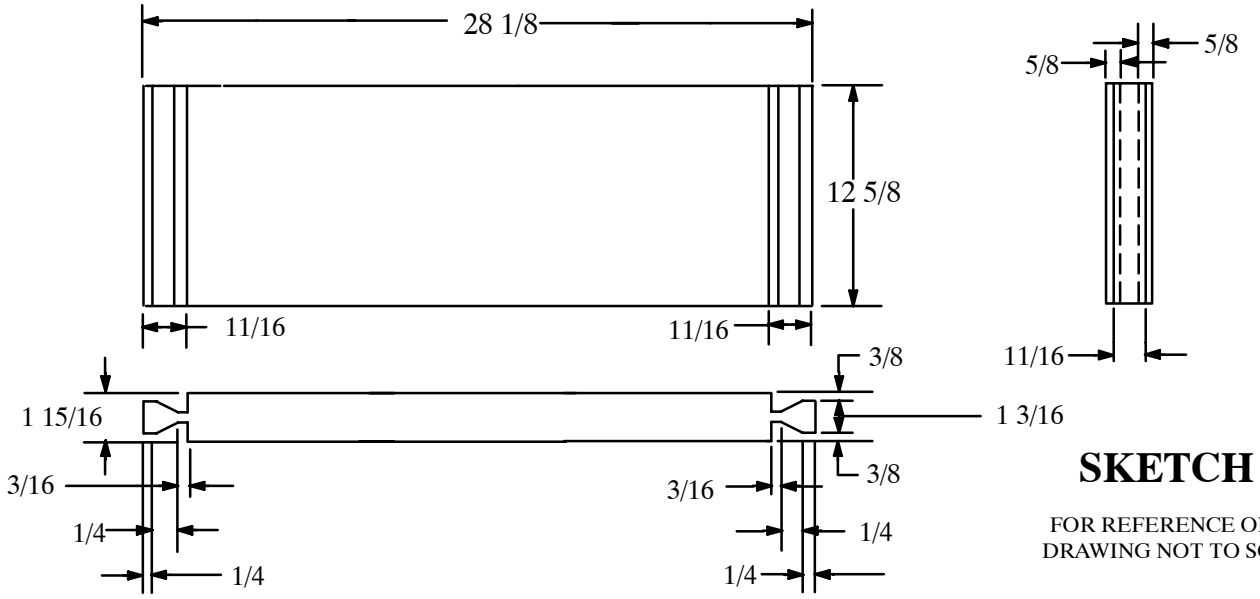




SKETCH 5

COOLER SIDE

(2 Required)



SKETCH 6

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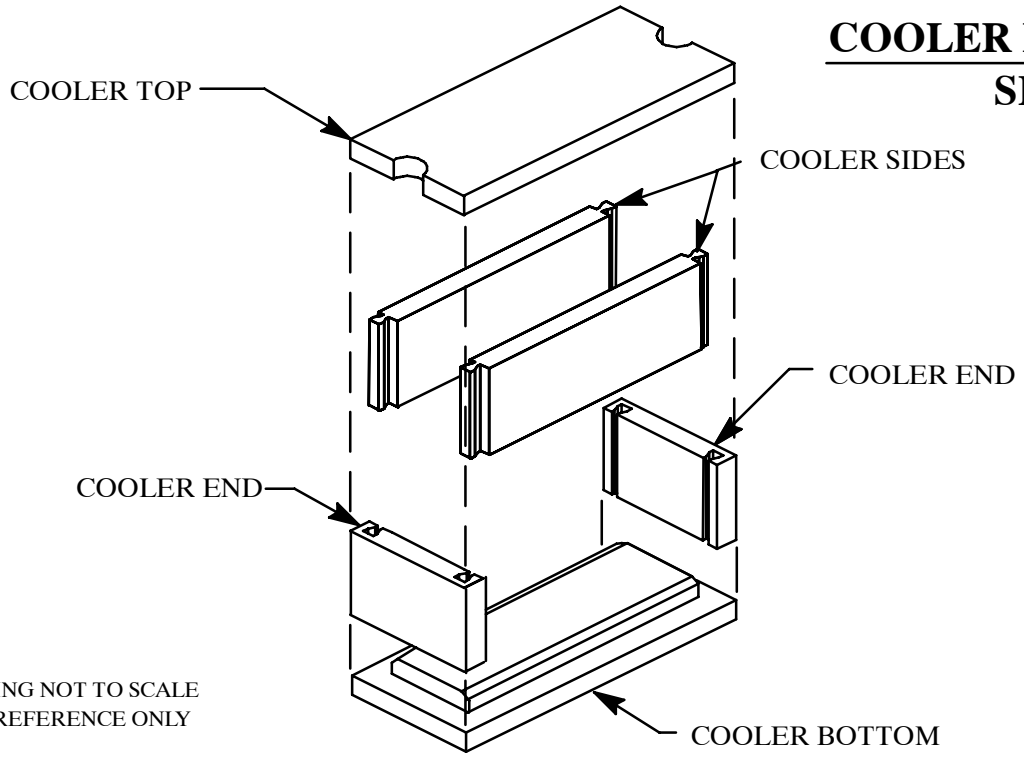
COOLER PACK ASSEMBLY
SKETCH 7



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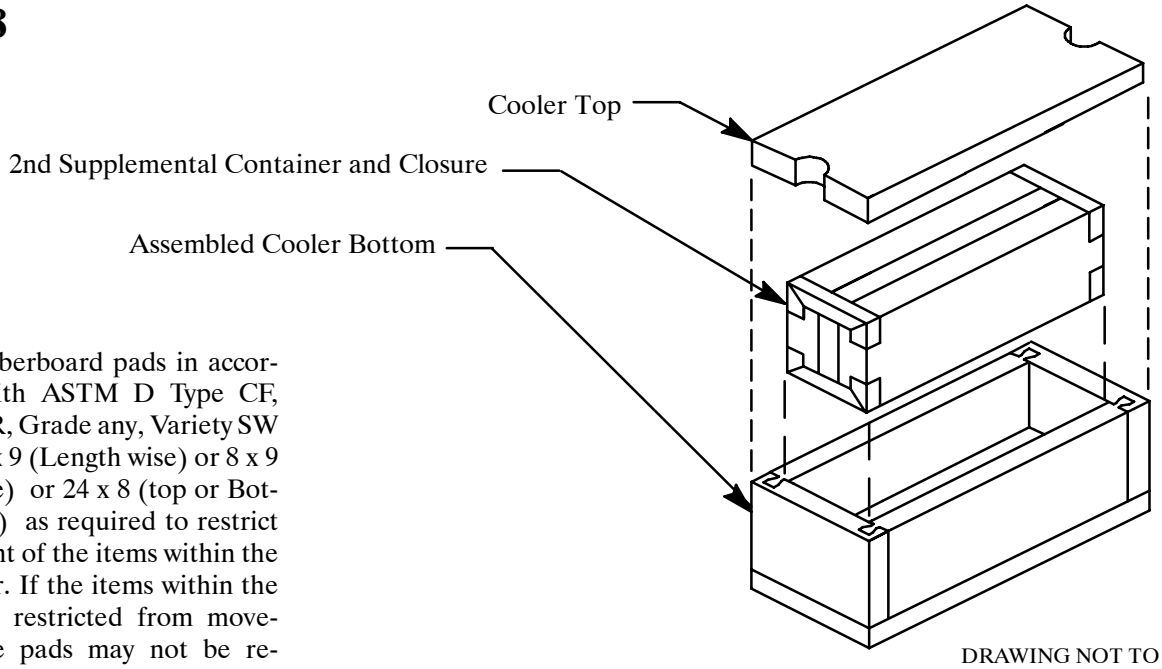
PLACEMENT OF THE PACKED 2nd SUPPLEMENTAL CONTAINER IN THE COOLER

SKETCH 8



NOTE: Apply fiberboard pads in accordance with ASTM D Type CF, Class WR, Grade any, Variety SW size 25 ax 9 (Length wise) or 8 x 9 (end wise) or 24 x 8 (top or Bottom wise) as required to restrict movement of the items within the container. If the items within the pack are restricted from movement the pads may not be required. Filler Pads are not shown in this sketch for clarity.

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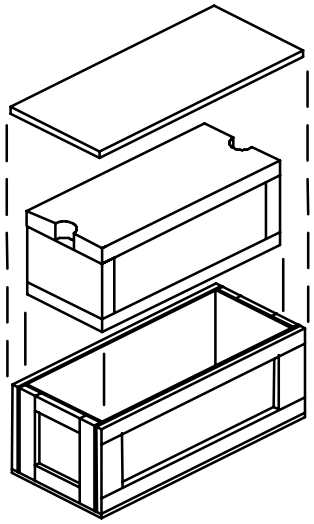
COOLER PACK PLACEMENT IN EXTERIOR CONTAINER

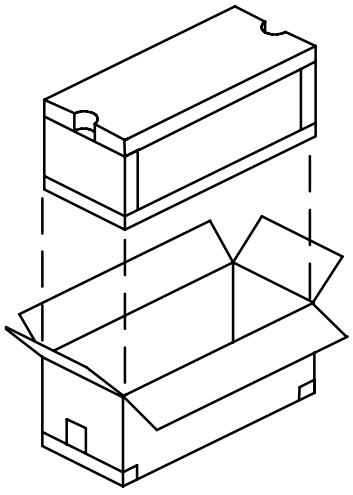
SKETCH 9



LEVEL A EXTERIOR CONTAINER

NOTE: Apply fiberboard pads in accordance with ASTM D Type CF, Class WR, Grade any, Variety SW size 28 x 10 (Length wise) or 11 x 10 (end wise) or 28 x 10 (top or Bottom wise) as required to restrict movement of the items within the container. If the items within the pack are restricted from movement the pads may not be required. Filler Pads are not shown in this sketch for clarity.

FOR REFERENCE ONLY
DRAWING NOT TO SCALE



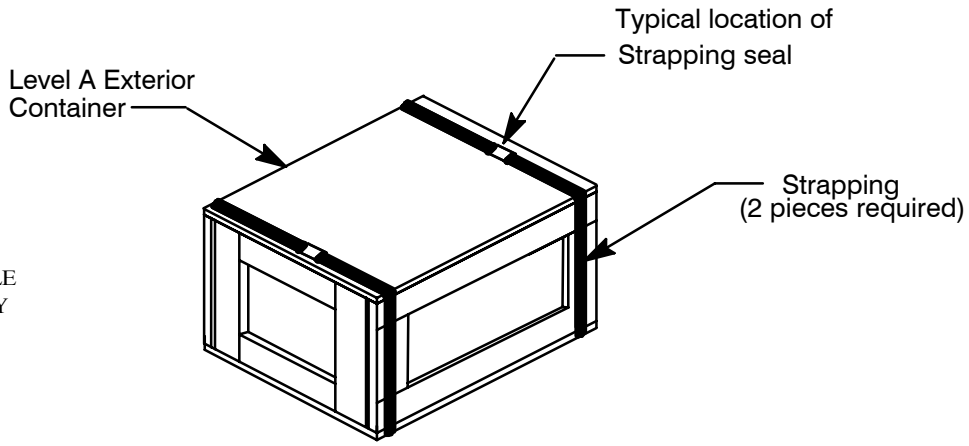
LEVEL B EXTERIOR CONTAINER

(Q) – Exterior Shipping Container. This SPI offers two levels of exterior shipping container. Level A Shall be used for overseas shipments and the B exterior shipping container may be used for domestic shipments only (see page 7, Sketch 9).

Level A, Exterior shipping container Eight (8) carrier assemblies shall be assembled into the cooler pack as shown on page 7 of this SPI. The cooler pack shall then be placed in the exterior shipping container in accordance with the sketch on page 7 of this SPI. The Level A exterior shipping container shall be a Class 2, Type III (Plywood only), Treatment A, cleated plywood box size 29 3/4 x 11 1/2 x 15 ID inches in accordance with ASTM D 6251. All paneling for the container shall be fabricated of plywood conforming to PS–1. Thickness of the plywood panels shall be a minimum of 3/16 inch. Oriented Strand Board (OSD) shall not be used.

Level A, Exterior shipping container closure. Closure shall be with 6 Penny box coated nails.

STRAPPING OF LEVEL A EXTERIOR CONTAINER



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FOR REFERENCE ONLY

Strapping of the Level A Shipping Container. Flat steel strapping shall be applied to the unit pack container as shown in the sketch above. Two straps are required. The strapping shall be placed on the Battens as shown in the sketch above. Strapping shall be Type 1, Heavy Duty, Finish B, Grade 2, minimum 3/8 inches in width x 0.012 inches in thickness length as required. The metal seals shall be of the correct size, Heavy duty, Finish B, Grade 2, Style any. Both strapping and seals shall be in accordance with ASTM D 3953. Once tensioned, the steel strappings shall be secured with metal seals of the correct size to effect a strong closure.

Level B, Exterior shipping container. Eight (8) carrier assemblies shall be assembled into the cooler pack as shown on page 7 of this SPI. The cooler pack shall then be placed in the exterior shipping container in accordance with the sketch on page 7 of this SPI. The Level B exterior shipping container shall be a RSC, Class WR, Grade V3c, Variety SW, Type CF, Fiberboard container size 29 3/4 x 11 1/2 x 15 ID inches ID in accordance with ASTM D 5118.

Level B, Exterior shipping container closure. The closure of the Level B exterior shipping con-

tainer shall be sealing method B of ASTM D 1974. Type V, tape in accordance with ASTM D 5486 shall be used.

(R) – The exterior shipping container specified in note (Q) shall serve as the exterior shipping container no intermediate shipping is required.

(S) – When shipping the carrier assemblies from the Manufacture to the depot they shall be shipped under active Temperature controls as specified in the contract.

(T) – In addition to the marking requirements of MIL–STD–129 the following markings shall be applied to the supplemental container step 5:

a. Pack Date
b. Expiration Date
c. Lot Number
d. Shelf Life Markings
e. Special Marking:

. "**Keep From Freezing, Keep from heat over 90 Degrees F.**"

Additional Special Markings The following additional markings shall be applied to the exterior shipping container:

a. Pack Date
b. Expiration Date
c. Lot Number
d. Shelf Life Markings
e. Special Marking:

"PROTECT FROM FREEZING
TEMPERATURE SENSITIVE MATERIAL
EXPEDITE SHIPMENT AND MOVEMENT
APPLY TEMPERATURE CONTROL AT FINAL DESTINATION"

The additional special markings as shown in (T) e. above shall be marked in red print at least 48 print and placed on the marking side of the exterior shipping container. If there is not enough room on the marking side of the container. The label shall then be placed on top of the exterior shipping container

(U) – In addition to the marking requirements found in note (T) apply one self adhering Temperature sensitive label on the marking surface of each inner barrier bag (step 2 of this SPI) and apply one self adhering Temperature sensitive label on the marking surface on each of the 8 outer barrier containers and (steps 4 of this SPI). Insure that the Temperature sensitive label does not cover any of the markings as required in note (T). The label shall be model, TL–S–140, manufactured by OMEGA Engineering Inc. P O Box 4047, Stamford, CT 06907–0047, Phone number 1–888–846–8865, Fax number (203) 359–7700. Web Site "www.omega.com".

(V) – Unit pack container (bag) leakage. The barrier bag (step 4) shall show no signs of leakage, as evidenced by a continuous stream of bubbles which appear at any surface when tested in accordance with Part V, 501 of this PQAP

(W) – Heat seal seam. The heat seal seam of the barrier bag (step 4) shall show no sign of heat seam separation when tested in accordance with Part V, 502 of this PQAP.

(X) – Packaging Quality Assurance Provisions (PQAP).

Part I – Applicable Documents

Military standards

MIL–STD–2073–1 – Standard Practice For Military Packaging

MIL–STD–3010 – Department of Defense Test Method Standard Test Procedures for Packaging Materials

Part II – Quality Provisions.

1. First Article Inspection. The first article packaging sample, shall be taken from the sample size of the Training Par Carrier Assemblies (drawing JPOPAR–20) as specified in the Contract or Quality plan used by the contractor and packaged in accordance with the military preservation requirements as specified in this SPI. The packaging sample size shall be 3 Training Par Carrier Assemblies and they shall be packaged in accordance with the military preservation requirements of this SPI. When an item requirement does not exist for a First Article Inspection, a packaging First Article Inspection sample is required. The sample shall consist of 3 Training Par Carrier Assemblies and shall be packaged in accordance with the military preservation requirements of this SPI, The First Article Inspection sample shall be submitted for inspection and approval in accordance the terms of the contract. In addition, 3 empty unit pack container (bag), step 4, shall be removed from the lot of bags and subjected to the destructive test in accordance with Part V, 502. The sample of empty bags shall be produced using the same methods, materials, and equipment as will be used during regular production. As determined by the Government, the packaging samples may be subjected to any or all of the examinations and tests specified in this PQAP and be inspected for compliance with any or all of the requirements of this SPI.

a. Acceptance Criteria. If any first article sample fails to comply with any of the requirements, the first article sample shall be rejected. The Government reserves the right to terminate inspection upon any failure to comply with any of the requirements.

2. Conformance Inspection.

a. Lotting. A lot shall consist of the items and packaging produced by one manufacturer, at one plant, from the same materials, under essentially the same manufacturing conditions, and shall not exceed one week's production. **However; when the packaging sample is produced at the same time as the item sample, lotting shall be as specified for the item, except that the items shall be packaged as specified herein.**

b. Sampling. Sampling shall be selected at random. Sampling shall be conducted in accordance with table I using the levels specified in Part III of this PQAP. If required, special sampling, inspection , and acceptance criteria are contained in Part III of this PQAP.

c. Inspection. Inspection shall consist of examination and test of all the characteristics contained in Part III and Part IV of this PQAP.

TABLE I. Sampling

Lot size	Inspection levels and sample sizes										
	I	II	III	IV	V	VI	VII	VIII	IX	X	XI
2 to 8	*	*	*	*	*	*	*	*	5	3	2
9 to 15	*	*	*	*	*	*	13	8	5	3	2
16 to 25	*	*	*	*	*	20	13	8	5	3	3
26 to 50	*	*	*	*	32	20	13	8	5	5	5
51 to 90	*	*	*	50	32	20	13	8	7	6	5
91 to 150	*	*	125	50	32	20	13	12	11	7	6
151 to 280	*	*	125	50	32	20	20	19	13	10	7
281 to 500	*	315	125	50	48	47	29	21	16	11	9
501 to 1200	*	315	125	75	73	47	34	27	19	15	11
1201 to 3200	1250	315	125	116	73	53	42	35	23	18	13
3201 to 10000	1250	315	192	116	86	68	50	38	29	22	15
10001 to 35000	1250	315	294	135	108	77	60	46	35	29	15
35001 to 150000	1250	490	294	170	123	96	74	56	40	29	15
150001 to 500000	1250	715	345	200	156	119	90	64	40	29	15
500001 and over	1250	715	435	244	189	143	102	64	40	29	15

*Indicates one hundred percent inspection. If sample size exceeds lot size, perform one hundred percent inspection.
Accept the lot represented on zero nonconforming characteristics and reject the lot represented on one or more nonconforming characteristics for all inspection levels.

3. Inspection equipment coding.
CE – Commercial inspection equipment
VI – Visual inspection

PART III – INSPECTION REQUIREMENTS
CLASSIFICATION OF CHARACTERISTICS

Category		Characteristic	Sampling and acceptance criteria	Inspection method
Critical				
		None Defined		
Major:				
		None Defined		
Minor				
	201	Item completely clean and dry prior to unit packaging	VL–VIII	VI
	202	Number and type of components that make up the Carrier Assemblies evident and correct	VL–VIII VL–VIII	VI VI
	203	Cushioning (step 1) correct and evident	VL–VIII	VI and CE
	204	Container (step 2) evident and correct	VL–VIII	VI and CE
	205	Desiccant (step 3) evident and correct	VL–VIII	VI and CE
	206	Barrier bag closure (step 4) evident and correct	VL–VIII	VI and CE
	207	Supplemental container (step 5) evident and correct	VL–VIII	VI and CE
	208	Supplemental container closure (step 6) evident and correct	VL–VIII	VI and CE
	209	2nd Supplemental container (step 7) evident and correct	VL–VIII	VI and CE
	210	2nd Supplemental container closure (step 8) evident and correct	VL–VIII	VI and CE
	211	Cooler top (step 9) evident and correct	VL–VIII	VI and CE
	212	Cooler bottom (step 10) evident and correct	VL–VIII	VI and CE
	213	Cooler end (step 11) evident and correct	VL–VIII	VI and CE
	214	Cooler side (step 12) evident and correct	VL–VIII	VI and CE
	215	Cooler pack assembly (see page 6) evident and correct	VL–VIII	VI and CE
	216	Placement of supplemental containers in assembled cooler pack (see page 7) evident and correct	VL–VIII	VI and CE
	217	Exterior container (step 13) evident and correct	VL–VIII	VI and CE
	218	Placement of cooler pack within exterior container (see page 7) evident and correct	VL–VIII	VI and CE
	219	Closure of exterior container (step 14) evident and correct	VL–VIII	VI and CE
	220	Steel Strapping and Seals (step 10) evident and correct	VL–VIII	VI and CE
	221	Filler Pads (note (J) (when Required) evident and correct	VL–VIII	VI and CE
	222	Filler Pads (Sketch 8) (when Required) evident and correct	VL–VIII	VI and CE
	223	Filler Pads (Sketch 9) (when Required) evident and correct	VL–VIII	VI and CE
	224	Temperature sensitive label (note U) evident and correct	VL–VIII	VI and CE

225	Unit pack container marking evident, correct, and legible	VL–VIII	VI and CE
226	Exterior shipping container marking evident, correct and legible	VL–VIII	VI and CE
227	Barrier bag leakage.	Part III, 301	Part V, 501
228	Barrier bag heat–seal seam strength.	Part III, 302	Part V, 502

SPECIAL SAMPLING, INSPECTION, AND ACCEPTANCE CRITERIA

301 Barrier bag leakage. Three barrier bags and their contents (step 4), packed for shipment, shall be selected at random from each lot and tested in accordance with Part V, 501 of this PQAP. Failure of any sample to meet the leakage requirement shall be cause for rejection of the lot from which the sample was drawn.

302 Barrier bag heat–seal seam (destructive test). Three empty barrier bags (steps 4) shall be selected at random from those being used for each lot of items and tested in accordance with Part V, 502 of this PQAP. Failure of any sample to meet the seam requirement shall be cause for rejection of the lot from which the sample was drawn.

PART IV – CERTIFICATION REQUIREMENTS Certification shall be required for each characteristic specified below and shall include actual examination and test results when required herein. Results of examinations shall be on file at the contractor's facility and shall be available to the Government for review.

Number	Characteristic	To comply with
401	Packaging material	Applicable specification or standard specified in this SPI.

PART V – TEST METHODS AND PROCEDURES

501 –Container (bag) leakage. The carrier assembly packaged in accordance with step 4 shall not leak when tested in accordance with Test Method, 5009, the Hot Water Technique, of MIL–STD–3010.

502 Heat–seal seam strength. The heat seal seam of the empty barrier bag step 4, shall be tested in accordance with Test Method 2024 of MIL–STD–3010.